


6509

	<b>Lark Engineering Co. (India)</b> ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)	Form No.	CNC/QA/FM/02
	<b>Inprocess Inspection (Pellet Dies)</b>	Rev. No.	01
		Rev. Date	31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10759	55/60
2	Machined By		V. T. L. H/C. Shop	Drg. No. = 10180-925
3	Pellet Die No.		11416 (3.5) H/H	Rev = 00
4	Die category	Drg. No.	Extravide	
5	Outside diameter	Drg. No.	640mm / Step 00 = 621.5mm	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 H/H	Step length = 21.5
7	Width Of Pellet Die	Drg. No.	222 H/H	
8	Grooves As Per Drawing	Drg. No.	13 x 8 x 5 H/H / 13 x 8 x 5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 214 H/H	Tapping Depth = 19 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date: Ravi 28/11/23

1	As per programme no.		_____
2	Gun Drilling Work Completed On		_____
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		No

Note: Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK		Rev = 35
2	External Relief Dia.	4.0 H/H	Outside / Inner	
3	External Relief Depth		12 H/H / 5 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28/11/23	

Inspected By (Sign) & Date: Ravi 28/11/23

  
 Reviewed by (Engineer (CNC))

Manager-QA