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Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		10834	43/50 ✓ 6355
3	Pallet Die No.		V.T.L n/c Shop	Dr. No. L.S.D
4	Die Category	Drg. No.	11099 (4.5) H4	Core Std ✓
5	Out Side Diameter	Drg. No.	Ext. outside	
6	Inside Diameter	Drg. No.	62.0 H4 Step OD 61.2 H4	Step length 9.5
7	Width of Pellet Die	Drg. No.	52.0 H4	
8	Grooves as per Drawing	Drg. No.	2.2 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	13.48 x 5 H4 / 13.48 x 5 H4	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping dia of holes = 12 Back Side
13	Tapping Hole Diameter		56.5 H4	
14	Tapping On Second Side	Half pitch of 1st side	H202 Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 21.3 H4	Tapping Depth 19.4
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 31/7/23

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							Ravi 29
2	External Relief Dia	5.0 H4	20 side (3-3)		Inner				
3	External Relief Depth	✓	12 H4		7 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Rorhore
6	Material Sent For Hardening On Date		8	12	23				

Inspected By (Sign) & Date

Ravi 31/7/23

Reviewed by (Engineer-CNC)

Manager-QA