


6519

 <b>Lark Engineering Co. (India)</b> ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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.		10816	30/50
2	Machined By		V.T.L. n/c Shop	Drg No. L.E.C-999
3	Pellet Die No.		11067 (3.0) n/c	Rev 2 00
4	Die category	Drg. No.	Extruder	
5	Outside diameter	Drg. No.	6.20 n/c, Step 00	Tapper: 12° Step length 18.5
6	Inside Diameter	Drg. No.	5.20.12 n/c	
7	Width Of Pellet Die	Drg. No.	222 n/c	
8	Grooves As Per Drawing	Drg. No.	13x8x5 n/c   13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No of Holes 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by H2-R11	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Rept. 21.4 n/c	Tapping Depth 19 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 29/11/23	
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	
<b>Note:</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Rev 2 38
2	External Relief Dia.	3.5 n/c	Outside 2.3-2.5	
3	External Relief Depth		2.3 n/c	Inner 2.0 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		29/11/23	
Inspected By (Sign) & Date			Ravi 29/11/23	

  
 29/11/23  
 Reviewed by (Engineer (CNC))

Manager-QA