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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10807	27/47
2	Machined By		V.T.L. H/C Shop	Drg. No. L. 20.15431
3	Pallet Die No.		11101 (3.0) H/H	Reo 200
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	614 H/H / Step OD = 612 H/H	Step length = 19.5 H/H
6	Inside Diameter	Drg. No.	590.12 H/H	
7	Width of Pellet Die	Drg. No.	222 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 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 Beta side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H200 Check by H200 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 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 11/12/23

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							
2	External Relief Dia	3.5 H/H	Outside (3-3)		Inner				Reo 28
3	External Relief Depth		2.3 H/H		2.0 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			11	12	23			
Inspected By (Sign) & Date		Ravi 11/12/23							

Reviewed by (Engineer-CNC)

Manager-QA