6588

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.		10790	35/40
2	Machined By		V.T.L. H/C Shop	Dg No. lark 9169 35510
3	Pallet Die No.		11516 (3.2) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 HH, Step OD: 395 HH	Step length 14.5
6	Inside Diameter	Drg. No.	32±0.12 HH	
7	Width of Pellet Die	Drg. No.	142 HH	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 HH / 15.5x7x2 HH	
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: 8 Both Side
12	Tapping PCD		355 HH / 354.9 HH	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 21.4 HH Tapping Depth: 19 HH	
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						Ravi 19
2	External Relief Dia	3.5 HH	Outside (3.2)		Innen			
3	External Relief Depth		1 HH		5 HH			
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					

Satya 11/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner