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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.		10827	32/40
2	Machined By		V.T.L. N/C Shop	Drg. No. L.S.D. 929
3	Pallet Die No.		11169 (5.0) H4	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	393 H4, Step 00, 383 H4	Step lengths 10 H4
6	Inside Diameter	Drg. No.	313.12 H4	
7	Width of Pellet Die	Drg. No.	146 H4	
8	Grooves as per Drawing	Drg. No.	14x6x3 H4 14x6x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No of holes = 8 Both side
11	Tapping Operator		N/C Shop	
12	Tapping PCD		352 H4	
13	Tapping Hole Diameter		0.518" / 0.314" Check by 0.518" / 0.314 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	One side Tapping 0.518" and 1st side 0.314"	
15	Tapping Hole Depth		Drill Depth 21.3 H4 Tapping Depth 19.2 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	Discussion over mail with

Inspected By (Sign) & Date

Ravi 16/12/23

1	As per programme no.			Mr. Prateek Sales. + Mr. Neeraj
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 15
2	External Relief Dia	5.5 H4	Outside (2-2)		Inner					
3	External Relief Depth		13 H4		8 H4					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			16	12	23				

Inspected By (Sign) & Date

Ravi 16/12/23

Reviewed by (Engineer-CNC)

Manager-QA