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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.			
2	Machined By		108-5	28/08/55
3	Pallet Die No.		V.T.L H/c Shop	Dy. No. 1892340
4	Die Category	Drg. No.	11422 (6.0) H/c	Rev 00
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	690H/c Step 002 682 H/c	Tapper = 12°
7	Width of Pellet Die	Drg. No.	580.12 H/c	Step length 34.5
8	Grooves as per Drawing	Drg. No.	266 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	28.5 x 6 x 12 H/c 28.5 x 6 x 12 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes = 12 Both side
12	Tapping PCD		630 H/c	
13	Tapping Hole Diameter		H/c Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 263 H/c	Tapping Depth 24 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 21/12/23*

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	6.5H/c 7.0H/c	6.5H/c All Lines	7.0H/c All Lines					
3	External Relief Depth		27H/c		17H/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		21	22	23				

Inspected By (Sign) & Date *Ravi 21/12/23*

Reviewed by (Engineer-CNC)

Manager-QA