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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11029	38/55
2	Machined By		V.T.L. n/c Shop	Drg. No. S.O. 407
3	Pallet Die No.		11569 (4.0) n/c	Rev. 200
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c Step 00, 692.8 n/c	Tapper 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	1278x7 n/c 1278x7 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		640 n/c	
13	Tapping Hole Diameter		H20 Check by H20 Roll	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 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 5/1/24

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

Counter: 60°

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 n/c	outside (3-3)		inner					
3	External Relief Depth		21 n/c		17 n/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Purchase					
6	Material Sent For Hardening On Date		5	1	24					

Inspected By (Sign) & Date

Ravi 5/1/24

Reviewed by (Engineer-CNC)

Manager-QA