

6229



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.		11020/	31/40
2	Machined By		V.T.L. n/c Shop	Drill: 18.0 - 768
3	Pallet Die No.		10980 (2.8) n/c	Rev: 00
4	Die Category	Drg. No.	540	
5	Out Side Diameter	Drg. No.	500 n/c, Step OD: 499 n/c	Step length: 20 n/c
6	Inside Diameter	Drg. No.	420.12 n/c	Tapper: 12°
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c / 12 x 8 x 3 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: 8 Back Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20 n/c Tapping	Depth: 12.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/1/24

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

1	Counter Sinking Depth & Finish	ok				Counter 60° Rev: 31
2	External Relief Dia	3.1 n/c	outside (2-2)		Inner	
3	External Relief Depth		15 n/c		9 n/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		6	1	24	

Inspected By (Sign) & Date

Ravi 6/1/24

Satyam
6/1/24

Reviewed by (Engineer-CNC)

Manager-QA