

6237



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.		11033	40/50
2	Machined By		V-T.L. n/c Shop	Drg No. 1.8.0-21
3	Pallet Die No.		11551 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm, Step 00, 499mm	Tapper = 12°
6	Inside Diameter	Drg. No.	42.12mm	Step length = 17mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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 Both Side
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		23.1mm - Check by 23.1mm Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.8mm, Tapping Depth = 19.7mm	
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°
2	External Relief Dia	4.5mm	outside (2-2)	inner			low = 20
3	External Relief Depth		14mm	10mm			
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