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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.		10989	45/50
2	Machined By		V.T.L. n/c Shop	Drg No = 1.8.0.13760
3	Pallet Die No.		11330 (4.0) n/c	Rev = 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52 n/c Step 00 = 49 n/c	Step length = 7.5
6	Inside Diameter	Drg. No.	42.12 n/c	
7	Width of Pellet Die	Drg. No.	158 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 Both 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 = 19.8 n/c	Tapping Depth = 17.2 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°
2	External Relief Dia	4.5 n/c	Outside (2-2)	Inner				Low = 20
3	External Relief Depth		13 n/c	5 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

Ravi
6/1/24
Reviewed by (Engineer-CNC)

Manager-QA