

6755



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.		11030	34/44/50
2	Machined By		V.T.L H/C Shop	Drg No. 1.2.02.633
3	Pallet Die No.		11389 (4.0) H4	Revol
4	Die Category	Drg. No.	55310	
5	Out Side Diameter	Drg. No.	619.8 H4, Step OD: 622.6 H4	Tapping 12
6	Inside Diameter	Drg. No.	520.12 H4	Step length: 2 H4
7	Width of Pellet Die	Drg. No.	186 H4	Under cut = 1.9 H4
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No of holes = 12 Bolt side
12	Tapping PCD		565 H4	
13	Tapping Hole Diameter		H/C = Check by H/C Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.3 H4	Tapping Depth = 19 H4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/1/24

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								Lead = 25
2	External Relief Dia	4.5 H4 / 5.0 H4	4.5 H4	All Lines	5.0 H4	All Lines				
3	External Relief Depth		16 H4		6 H4					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		11	1	24					

Inspected By (Sign) & Date Ravi 11/1/24

Reviewed by (Engineer-CNC)

Manager-QA