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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.		11101	
2	Machined By		V. T. L. H/c Shop	30/40 3195 Dy. Lark 3310
3	Pallet Die No.		10957 (B.5) H/H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H Step 02 498 H/H	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/H / 12 x 8 x 3 H/H	
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 = 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		H20 x Check by wire Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 19.8 H/H Tapping Depth = 17.3	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 15/1/24

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° Rows 22
2	External Relief Dia	4.0 H/H	outside (2-2)		Inner			
3	External Relief Depth		14 H/H		10 H/H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		13	1	24			

Inspected By (Sign) & Date

Ravi 15/1/24

Reviewed by (Engineer-CNC)

Manager-QA