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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.		11087.	29/40
2	Machined By		V.T.B. H/c Shop	Drg. No. 195 370
3	Pallet Die No.		10947 (3.0) H/H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H Step OD = 49 H/H	Step length = 18.5
6	Inside Diameter	Drg. No.	420 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes = 8 Both Side
12	Tapping PCD		454 H/H	
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 H/H Tapping Depth: 17.3 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/1/24

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					Center = 60°
2	External Relief Dia	3.5 H/H	outside (2-2)		Inner		160 = 24
3	External Relief Depth		14 H/H		11 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		16	1	24		

Inspected By (Sign) & Date

Ravi 16/1/24

Reviewed by (Engineer-CNC)

Manager-QA