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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.		11147	37/40
2	Machined By		V.T.L H/C Shop	Digital Lock 9.95 3.10
3	Pallet Die No.		10949 (3.5) H/C	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C Step OD = 49 H/C	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C 12 x 8 x 3 H/C	
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/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 H/C	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 17/1/24

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 Sinking	Depth	Finish	Outside	Inner	Other
1	OK					
2	3.8 H/C			outside (2-2)	Inner	
3				7 H/C	3 H/C	
4	Inspection Done Before Hardening By (Name) <u>Ravi</u>					
5	Material Sent For Hardening By (Name) <u>Lark Rosmore</u>					
6	Material Sent For Hardening On Date <u>17 1 24</u>					

Inspected By (Sign) & Date Ravi 17/1/24

Reviewed by (Engineer-CNC) Satya 17/1/24

Manager-QA