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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.		11127	30/50
2	Machined By		V.T.L. n/c Shop	Drg No. 130-960
3	Pallet Die No.		11701 (B.O.) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c, Step 002 490 n/c	Step length 14.4
6	Inside Diameter	Drg. No.	420 n/c	
7	Width of Pellet Die	Drg. No.	160 n/c	
8	Grooves as per Drawing	Drg. No.		
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 Roh Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		03/16" Check by 03/16" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 n/c Tapping Depth 17.3 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 20/1/24

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							
2	External Relief Dia	7.0 n/c	All keys						
3	External Relief Depth		20 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		20	1	24				

Inspected By (Sign) & Date Ravi 20/1/24

[Signature]
Reviewed by (Engineer-CNC)

Manager-QA