

6809



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.		11106	45/50
2	Machined By		V.T.L H/c Shop	Qty Holes: 120
3	Pallet Die No.		11460 (4.0) H/c	Rev: 00
4	Die Category	Drg. No.	Embawide	
5	Out Side Diameter	Drg. No.	620 H/c	Step 002 Tapper 12° Step length = 18.5
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	Tapping No. of holes = 12 Botu Side
13	Tapping Hole Diameter		H202 Check by H20 Botu	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.3 H/c	Tapping Depth 19 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/11/24

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: 600

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/c	outside (2-3)		Inner					
3	External Relief Depth		13 H/c		5 H/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		19	1	24					

Inspected By (Sign) & Date

Ravi 19/11/24

Reviewed by (Engineer-CNC)
Satyajit 19/11/24

Manager-QA