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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.		11112	28/48/66
2	Machined By		V.T.L. n/c Shop	Dry No. (i.s.d) 309
3	Pallet Die No.		11484 (G.O) n/c	Revol
4	Die Category	Drg. No.	H. Jumbo	(A)
5	Out Side Diameter	Drg. No.	680.69 n/c Step OD = 692.3 n/c	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut = 2.4 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 n/c
10	Drilling Area Surface Smoothness		ok	Deep Bot side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619 n/c	of Holes = 4
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/c	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

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

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						Counters 30°
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Rows	7.0 n/c All Rows				
3	External Relief Depth	/	38 n/c	18 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		24	1	24			

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

Reviewed by (Engineer-CNC) [Signature]

Manager-QA