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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.		11063	45/50
2	Machined By		V.T.L. n/c Shop	Drg. No. 13.02.42
3	Pallet Die No.		11714 (8.0) n/c	Revised
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c, Step OD = 492 n/c	Step length 13.4
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	159 n/c	
8	Grooves as per Drawing	Drg. No.	7x7x5 n/c / 7x7x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of holes on Both Side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		002 1/4" - Check by 002 1/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 23 n/c Tapping Depth. 20.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 30/1/24	2 slot 20.1 n/c width 7 n/c Depth Both Side
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 Counters 60°				
1	Counter Sinking Depth & Finish	ok		Ravi 12
2	External Relief Dia	8.3 n/c	outside (2-2)	Inner
3	External Relief Depth		13 n/c	5 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		13/01	1 24
Inspected By (Sign) & Date			Ravi 30/1/24	

Reviewed by (Engineer-CNC)

Manager-QA