

6855



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.		1114	50/80
2	Machined By		V.T.L. n/c Shop	Drg No. 1.2.02 409
3	Pallet Die No.		10197 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	640 n/c Step 002 612 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	580.12 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 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. 12 Rake Side
12	Tapping PCD		565 n/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 81.4 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/1/24

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

Count per 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c	outside (3.3)		inner				
3	External Relief Depth		18 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forcare				
6	Material Sent For Hardening On Date		28	1	24				

Inspected By (Sign) & Date

Ravi 28/1/24

Reviewed by (Engineer-CNC)
Sachin 29/1/24

Manager-QA