

6823



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.		11116	48/48
2	Machined By		V.T.L. H/c Shop	Drg. No. 13.0-900
3	Pallet Die No.		8515 (4.0) H/c	Rev. 00
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	796.2 H/c	Step 00 = 799.8 H/c Tapper = 4"
6	Inside Diameter	Drg. No.	700.12 H/c / 700.14 H/c (A)	Step length = 27
7	Width of Pellet Die	Drg. No.	320 H/c	Under cut = 1.2 H/c
8	Grooves as per Drawing	Drg. No.	25 x 10 x 9 H/c / 25 x 10 x 9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		750 H/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 = 36.3 H/c	Tapping Depth = 34.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/1/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK (A)
4	Defective Holes (If Any)		None - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60

1	Counter Sinking Depth & Finish	OK								Ravi, GU
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner					
3	External Relief Depth		4 H/c		Mill					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Rorance
6	Material Sent For Hardening On Date			23	1	24				

Inspected By (Sign) & Date

Ravi 23/1/24

(Signature)
23/1/24

Reviewed by (Engineer-CNC)

Manager-QA