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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11162	02/55
2	Machined By		V.T.L. H/c Shop	Drg No. 1.3.2-4.7
3	Pallet Die No.		11579 (4.0) H/c	Rev 2.00
4	Die Category	Drg. No.	M. Torpedo	
5	Out Side Diameter	Drg. No.	710 H/c, Step 002 692.8 H/c	Tapless 12°
6	Inside Diameter	Drg. No.	650.12 H/c	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222.1 H/c	
8	Grooves as per Drawing	Drg. No.	12+8+7 H/c 12+8+7 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		640 H/c	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21.4 H/c	Tapping Depth = 18.9 H/c
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	_____	
2	External Relief Dia	4.5 H/c	Outside (2-3)	Inner
3	External Relief Depth		21 H/c	17 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porcelain	
6	Material Sent For Hardening On Date		24	24
Inspected By (Sign) & Date			Ravi 24/1/24	

Reviewed by (Engineer-CNC)

Manager-QA