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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.		11123	45/45
2	Machined By		V. T. L. n/c Shop	Dy No. 130 = 864
3	Pallet Die No.		11426 (G.O) n/c	Rev 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400mm	
6	Inside Diameter	Drg. No.	Step 02, 383mm	Step length 114
7	Width of Pellet Die	Drg. No.	310.12 mm	
8	Grooves as per Drawing	Drg. No.	135 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		350 mm	
14	Tapping On Second Side	Half pitch of 1st side	0.25" - Check by 0.25 Bolt	Tapping No of holes 8 Rake side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.8 mm - Tapping Depth 18.7	
17	Visual Inspection Before Gun Drilling		yes	
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		6.5 mm	Row 11
3	External Relief Depth		6 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravnace	
6	Material Sent For Hardening On Date		24 / 1 / 24	
Inspected By (Sign) & Date			Ravi 24/1/24	

Reviewed by (Engineer-CNC)

Manager-QA