

6859



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.		11178	40/40
2	Machined By		V.T.G. H/c Shop	Drg. No. 130-881
3	Pallet Die No.		10984 (3-0) H/c	Recd
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	500 H/c / Step 00 = 490.7 H/c	Step length 16.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	173.1 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 5 H/c / 12 x 10 x 5 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 = 8 Both side
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		0.314" = Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 21.5 H/c / Tapping Depth = 19 H/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

Counter: 60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	2.5 H/c	outside (2-2)	Inner			
3	External Relief Depth		6 H/c	Nil			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Burnace				
6	Material Sent For Hardening On Date		28	1	24		

Inspected By (Sign) & Date

Ravi 28/1/24

Satish 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA