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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11155	40/50
2	Machined By		V.T.L. n/c Shop	Dy No. 13.02 964
3	Pallet Die No.		11595 (3.0) n/c	Raw 00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	62 n/c, Step 002 621 n/c	Step length 2.5 n/c
6	Inside Diameter	Drg. No.	52 n/c	Tappers 12"
7	Width of Pellet Die	Drg. No.	222.1 n/c	Under cut. 0.5 n/c
8	Grooves as per Drawing	Drg. No.	14x8x9 n/c 14x8x9 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M2x2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.0 n/c	Tapping Depth 12.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/1/24

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 = 600

1	Counter Sinking Depth & Finish	OK							Raw 238
2	External Relief Dia	2.3 n/c	Outside (3-3)		Inner				
3	External Relief Depth		16 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		29	1	24				

Inspected By (Sign) & Date

Ravi 29/1/24

29/1/24

Reviewed by (Engineer-CNC)

Manager-QA