

6876



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.		11185	36/42
2	Machined By		V.T.L. H/c Shop	Dy. No. 1-3-0 970
3	Pallet Die No.		11609 (3.10) H/c	Rev. 01
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	604 H/c Step 002-612 H/c	Step length 2.2 H/c
6	Inside Diameter	Drg. No.	520.12 H/c	Under cut 4 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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		565 H/c	
13	Tapping Hole Diameter		M20 - Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.2 H/c Tapping Depth 18.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/1/24

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

Counters 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	2.5 H/c	All Rows						
3	External Relief Depth		6 H/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		30	1	24				

Inspected By (Sign) & Date

Ravi 30/1/24

Reviewed by (Engineer-CNC)
S. J. 20/1/24

Manager-QA