

6905



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.		11204	35/50
2	Machined By		V.T.L. H/C Shop	6355 Dy. No. last 5812
3	Pallet Die No.		11610 (3.5) H/C	
4	Die Category	Drg. No.	2x2 outside	
5	Out Side Diameter	Drg. No.	620 H/C, Step 002 612 H/C	3 step length = 19.4
6	Inside Diameter	Drg. No.	520.12 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 Bob side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.4 H/C	Tapping Depth: 18.2 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/2/24

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 = 605

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	3.8 H/C	outside (2-3)		inner					
3	External Relief Depth		18 H/C		15 H/C					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Romare
6	Material Sent For Hardening On Date			5	2	24				

Inspected By (Sign) & Date

Ravi 5/2/24

Reviewed by (Engineer-CNC)

Manager-QA