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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)

Sl. No.	Check Parameter	Specification	Observations	Remarks
16	Work Order No.		11232	36/44/50
	Machined By		V.T.L. N/C Shop	Dytl-62014805
	Pallet Die No.		8892 (3.0) M4	Revised
4	Die Category	Drg. No.	M420	
5	Out Side Diameter	Drg. No.	70 M4 Step 002 Tapper	12° Step length 17.1
6	Inside Diameter	Drg. No.	60.12 M4	
7	Width of Pellet Die	Drg. No.	28.5 M4	
8	Grooves as per Drawing	Drg. No.	15x8x7 M4 / 15x8x7 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping H. of Holes 16 Both Side
12	Tapping PCD		64.0 M4	
13	Tapping Hole Diameter		M202 Check by H 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 M4 Tapping Depth 18.8 M4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ravi 9/2/24*

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

1	Counter Sinking Depth & Finish	OK						Counter 60°
2	External Relief Dia	3.5 M4 / 4.0 M4	3.5 M4	All Raps	4.0 M4	All Raps		Raps 47
3	External Relief Depth	/		14 M4		6 M4		
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>					
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>					
6	Material Sent For Hardening On Date		9	2	24			

Inspected By (Sign) & Date *Ravi 9/2/24*

Reviewed by (Engineer-CNC) *Satyam 9/2/24*

Manager-QA