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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.		9666	32/42/50
2	Machined By		V.T.L. H/c Shop	Drg No. 1-S.D. 419
3	Pallet Die No.		9840(4.0) H/c	Reo 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c Step 0.02 690 H/c	Step length 19.4
6	Inside Diameter	Drg. No.	600 H/c	(B)
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	18.5 x 8 x 7 H/c / 18.5 x 8 x 6.9 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 Bot Side
12	Tapping PCD		645 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.4 H/c Tapping Depth 20.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/6/23

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								
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c All Lines			5.0 H/c All Lines				For 2 32
3	External Relief Depth		18 H/c			8 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		3	6	23					

Inspected By (Sign) & Date

Ravi 31/6/23

5/6/23

Reviewed by (Engineer-CNC)

Manager-QA