5792

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.		9865	31/50
2	Machined By		V.T.L N/C Shop	Dwg No: L.E.C/998 Rev: 00
3	Pallet Die No.		10624 (2.8) MM	
4	Die Category	Drg. No.	Carbaside	
5	Out Side Diameter	Drg. No.	620 MM, Step OD: Tapped, 12" Step length 18 MM	
6	Inside Diameter	Drg. No.	520.4 MM	
7	Width of Pellet Die	Drg. No.	22.2 MM	
8	Grooves as per Drawing	Drg. No.	13x8x5 MM / 13x8x5 MM	
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 MM	
13	Tapping Hole Diameter		M20 x 2.5 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth: 20.4 MM Tapping Depth = 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 12/7/23	
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						Row 4
2	External Relief Dia	3.1 MM	Outside (3-3)		Inner			
3	External Relief Depth		25 MM		19 MM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		12	7	23			
	Inspected By (Sign) & Date		Ravi 12/7/23					

12/7/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner