

6982



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.		11263	35/40
2	Machined By		V.T.L. H/c Shop	Qty Nos 130 2865
3	Pallet Die No.		11554 (4.0) H/H	Rev 00
4	Die Category	Dr. No.	Junior	
5	Out Side Diameter	Dr. No.	39.0 H/H, Step OD = 38.3 H/H	Step length 11.5
6	Inside Diameter	Dr. No.	31.0 ± 0.12 H/H	
7	Width of Pellet Die	Dr. No.	135 H/H	
8	Grooves as per Drawing	Dr. No.	12 x 8 x 3 H/H / 12 x 8 x 3 H/H	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of holes B Both Side
12	Tapping PCD		35.0 H/H	
13	Tapping Hole Diameter		0314" ± Check by 0314 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 81 H/H Tapping Depth 19 H/H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/2/24

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						Count 1360
2	External Relief Dia	4.5 H/H	Outside (2-2)		Inner			
3	External Relief Depth		9 H/H		5 H/H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		21	2	24			

Inspected By (Sign) & Date

Ravi 21/2/24

Reviewed by (Engineer-CNC)

Manager-QA