

5596

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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		9656	32/42/50
3	Pallet Die No.		V.T.C n/c Shop	Qty nos 18.02 415
4	Die Category	Drg. No.	10308 (4.0) n/c	Rev 2 of
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 n/c Step OD = 499 n/c	Tapper = 12°
7	Width of Pellet Die	Drg. No.	4201 n/c	Step length = 19.8
8	Grooves as per Drawing	Drg. No.	158 n/c	(B)
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		454 n/c	Tapping No. of Holes = 8
14	Tapping On Second Side	Half pitch of 1st side	M20 - Check by M20 Bolt	Back side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.4 n/c	Tapping Depth = 16.8 n/c
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 11/6/23

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		ok No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	4.5mm / 5.0mm	4.5mm All Lines	5.0mm All Lines		Per 20
3	External Relief Depth		18mm	8mm		
4	Inspection Done Before Hardening By (Name)					
5	Material Sent For Hardening By (Name)				Ravi	
6	Material Sent For Hardening On Date				Lark Furnace	
			1	6	23	

Inspected By (Sign) & Date

Ravi 11/6/23

Reviewed by (Engineer-CNC)

Manager-QA