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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.		11524	120/120
2	Machined By		V.T.C H/C Shop	Drg No. L3.0-5597
3	Pallet Die No.		12236 (4.0) H/C	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	870 H/C, Step 002 743.3 H/C	Tapper = 16
6	Inside Diameter	Drg. No.	630.14 H/C (A)	
7	Width of Pellet Die	Drg. No.	265 H/C	
8	Grooves as per Drawing	Drg. No.	15x8x5 H/C 15x8x5 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 = 16 Both side]
12	Tapping PCD		685 H/C	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 21 H/C	Tapping Depth, 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/4/24

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

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

1	Counter Sinking Depth & Finish	ok								Ravi 23/7
2	External Relief Dia	-								No - Relief
3	External Relief Depth	-								
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Keshav
6	Material Sent For Hardening On Date									3 4 24

Inspected By (Sign) & Date

Ravi 21/4/24

Reviewed by (Engineer-CNC)
Satyam 21/4/24

Manager-OA