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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.		9889	30/55
2	Machined By		V.T.L n/c Shop	Dy No. 1-82-347
3	Pallet Die No.		9409 (G.O) n/c	Round
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	630 n/c	Step length 19.9 n/c
6	Inside Diameter	Drg. No.	520.14 n/c	
7	Width of Pellet Die	Drg. No.	229 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x4.9 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Nod Holes: 12 Bolt Side
12	Tapping PCD		565 n/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: 20.4 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 20/7/23

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							Ravi 23
2	External Relief Dia	6.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		31 n/c		25 n/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		20	7	23				

Inspected By (Sign) & Date Ravi 20/7/23

[Signature]
20/7/23
Reviewed by (Engineer-CNC)

Manager-QA