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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9941	38/50
2	Machined By		V.T.L. H/c Shop	6385 Dry No. Leak 3310
3	Pallet Die No.		10616 (3.8) H/c	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step length 19.4
6	Inside Diameter	Drg. No.	5.20.12 H/c	(2)
7	Width of Pellet Die	Drg. No.	2.22 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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 = 12 Both Side
12	Tapping PCD		56.5 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 20.5 H/c	Tapping Depth 18.5 H/c
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							Row = 33
2	External Relief Dia	4.3 H/c	outside (3.3)		Inner				
3	External Relief Depth		16 H/c		12 H/c				
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Porhore						
6	Material Sent For Hardening On Date		20	7	23				

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

Reviewed by (Engineer-CNC)

Manager-QA