

5846



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.		9916	29/40
2	Machined By		V.T. L.M/C Shop	Drg No. Lark SS-10
3	Pallet Die No.		9808 (3.0) H	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H Step OD. 490.7 H	Step length 12.4
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H / 11.8x8x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping H ₀ of H ₀ ce. 8 Both Side
12	Tapping PCD		454 H	
13	Tapping Hole Diameter		H20 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 H	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 24/7/23

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							
2	External Relief Dia	3.5 H	outside (2-2)		Inner				Ravi 24
3	External Relief Depth		14 H		11 H				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Bhat Metals				
6	Material Sent For Hardening On Date		24	7	23				

Inspected By (Sign) & Date Ravi 24/7/23

Reviewed by (Engineer-CNC)

Manager-QA