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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.		9704	45/70
2	Machined By		V.T.L n/c Shop	Dy No. 1-EC2 1202
3	Pallet Die No.		10766 (3.0) n/c	Rev 01
4	Die Category	Drg. No.	Si-Jumbo	
5	Out Side Diameter	Drg. No.	1287 n/c, Step OD - 1283 n/c	Step length 28 n/c
6	Inside Diameter	Drg. No.	1145.12 n/c	
7	Width of Pellet Die	Drg. No.	388.5 n/c	
8	Grooves as per Drawing	Drg. No.	28x8x13 n/c 28x8x13 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No of Holes 2 & Both Side
12	Tapping PCD		1210 n/c	
13	Tapping Hole Diameter		M24 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 31/7/23

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 - 1 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 n/c	outside 2.9-4)		Inner				Raw: 67
3	External Relief Depth		31 n/c		25 n/c				
4	Inspection Done Before Hardening By (Name)								Raw
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		231	7	23				

Inspected By (Sign) & Date

Raw: 31/8/23

Reviewed by (Engineer-CNC)

Manager-QA