

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.			
2	Machined By		12303	30/50
3	Pallet Die No.		V.T.L. H/c Shop	Dy No. 1202/415
4	Die Category	Drg. No.	12318(5.0) H/c	Revised
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	5.20 H/c Step 00.489 H/c	Tapping 12
7	Width of Pellet Die	Drg. No.	4.20.12 H/c	Step length 2.8 H/c
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping H/c of holes 8 Bolt Side
13	Tapping Hole Diameter		4.54 H/c	
14	Tapping On Second Side	Half pitch of 1st side	H/c Check by H/c Bolt	
15	Tapping Hole Depth		OK	Tapping Bolt 10.5
16	Perpendicularity of Tapped Hole		Drill Depth 18.3 H/c	
17	Visual Inspection Before Gun Drilling		yes	
			OK	

Inspected By (Sign) & Date

Ravi 8/7/24

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	5.5 H/c	80 Side (2-2)	Inner					
3	External Relief Depth	2.5 H/c		2.0 H/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		8	7	24				

Inspected By (Sign) & Date

Ravi 8/7/24

Reviewed by (Engineer-CNC)

Manager-QA