

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.		12576	35/40
2	Machined By		V. T. K. H/c Shop	Drg No. 1202 502
3	Pallet Die No.		11391 (4.0) mm	Removal
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm Step 002 498.8	Tapper 12
6	Inside Diameter	Drg. No.	420.12 mm	Step length 18.5
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm 12x8x3 mm	
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 = 8
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 7/8/24

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							Counter: 60
2	External Relief Dia	4.5 mm	Outside 2-2	Inner					
3	External Relief Depth		8 mm	4 mm					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Ravnare
6	Material Sent For Hardening On Date								7 8 24

Inspected By (Sign) & Date

Ravi 7/8/24

Reviewed by (Engineer-CNC)

Manager-QA