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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.		12869	53/58
2	Machined By		V.T.L. M/c Shop	Drg No. L-2-C-5980
3	Pallet Die No.		13019 (3.8) mm	Rev-00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	77.6 mm	Step 00, 800 mm, Step length
6	Inside Diameter	Drg. No.	66.0-12 mm	
7	Width of Pellet Die	Drg. No.	316 mm	
8	Grooves as per Drawing	Drg. No.	20x8x7.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		72.5 mm	Tapping No. of Holes = 12 Both Side
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: 25.4 mm	Tapping Depth: 23.1
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/9/24

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	4.3 mm	outside (3-3)	Inner			low: 42
3	External Relief Depth		12 mm	5 mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		19	9	24		

Inspected By (Sign) & Date

Ravi 19/9/24

Reviewed by (Engineer-CNC)

Manager-QA