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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.		12995	40/55
2	Machined By		V.T.L. H/c Shop	Dy H., L.S., B55
3	Pallet Die No.		12678 (3.8) H/c	Raoz
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	630 H/c / Step OD = 612 H/c	Step length 2mm
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of hole, 12 Rolo Side
12	Tapping PCD		565 H/c	
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 20.4 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/10/24

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

Counter: 600

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.3 H/c	outside (3-3)		Inner					
3	External Relief Depth		19 H/c		15 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			4	10	24				

Inspected By (Sign) & Date

Ravi 4/10/24

Reviewed by (Engineer-CNC)
Surya 4/10/24

Manager-QA