

8398



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.		12998	33/40
2	Machined By		V. T. L. n/c Shop	Drg. No. 3310
3	Pallet Die No.		13511 (3.0)	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.50 mm, 2 step 0.2 = 2.95 mm	Step length 1.42
6	Inside Diameter	Drg. No.	3.20-1.2 mm	
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm / 15.5 x 7 x 2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping W. of holes @ Both Side
12	Tapping PCD		355 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/10/24

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 Sink

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 mm	Outside (2-2)		Inner				
3	External Relief Depth		1.3 mm		Fin				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark For more
6	Material Sent For Hardening On Date		18	10	24				

Inspected By (Sign) & Date

Ravi 18/10/24

Reviewed by (Engineer-CNC)
S. S. 18/10/24

Manager-QA