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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.		12983 ✓	36/50
2	Machined By		V. T. L. H/C Shop	Dry Hole 1.9.02 25-01
3	Pallet Die No.		12555 (3.0) H/C ✓	Rev 201
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C Step OD = 693 H/C ✓	Tapped ✓
6	Inside Diameter	Drg. No.	600.12 H/C ✓	Step length = 20 H/C ✓
7	Width of Pellet Die	Drg. No.	222 H/C ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 12x8x7 H/C ✓	
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 = 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth = 20.4 H/C ✓	Tapping Depth = 28.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/10/24

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 - 2 Hole Colored (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60

1	Counter Sinking Depth & Finish	ok							Row = 39
2	External Relief Dia	3.5 H/C ✓	outside (3-3)		Inner				
3	External Relief Depth		20 H/C		14 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Portace
6	Material Sent For Hardening On Date		17	10	24				

Inspected By (Sign) & Date

Ravi 17/10/24

Reviewed by (Engineer-CNC)
 17/10/24

Manager-QA