

8396



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.		12968 ✓	55/66 ✓
2	Machined By		V. T. L n/c Shop	Drg No. 129210A5
3	Pallet Die No.		12932 (8.0) ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680 ✓ Step 60, 692.5 ✓	Tappes = 5°
6	Inside Diameter	Drg. No.	547.9 ✓	Step Length = 28 ✓
7	Width of Pellet Die	Drg. No.	215 ✓	Width = 3.15 ✓
8	Grooves as per Drawing	Drg. No.	30.5 x 6 x 8.1 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side 34 ✓
10	Drilling Area Surface Smoothness		OK	Deep Both Side ✓
11	Tapping Operator		n/c Shop	Tapping No. of Holes & Both Side
12	Tapping PCD		620 ✓	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 32.7 ✓	Tapping Depth = 30.3
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

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

Counter = 30°
Rows = 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	9.0 ✓		All Rows			
3	External Relief Depth			11 ✓			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Porrace			
6	Material Sent For Hardening On Date		17	10	24		

Inspected By (Sign) & Date

Ravi 17/10/24 ✓

Satya 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA