

8406



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.		13153	55/60
2	Machined By		V.T.L n/c Shop	Dy. No. 18.0.320
3	Pallet Die No.		12895(8.0) n/c	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	88.0 n/c Step 00, 693 n/c	Topless 8
6	Inside Diameter	Drg. No.	548 n/c	Step length 9 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Width of 98 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c 32 x 7 x 8 n/c	(4 x 2) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Face side step 9 n/c Back side]
12	Tapping PCD		619 n/c	[Tapping No. of holes 2]
13	Tapping Hole Diameter		N16 Check by N16 Bolt	[Back side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34 n/c	Tapping Depth 31.6
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	Disaus with Neeraj side
4	Defective Holes (If Any)		No	OK ↓

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

Counters 300 Rows 10

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	0.0 n/c	11 Rows					
3	External Relief Depth		11 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Porrace					
6	Material Sent For Hardening On Date		18	10	24			

Inspected By (Sign) & Date

Ravi 18/10/24

Saty 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA