

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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13054 ✓	50/50 ✓
2	Machined By		V. T. L. H/c Shop	Dy. No. 6.9.01 3760
3	Pallet Die No.		12315 (4.0) H/c	Rev. No.
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	520 H/c	Step 002 49 H/c Step length 175
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	138 H/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping H. of Holes: 8 Both Side
12	Tapping PCD		454 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: 18.4 H/c	Tapping Depth: 6.6
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
4	Defective Holes (If Any)		No

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

Counter: 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H/c	Outside (2-2)	Inner					
3	External Relief Depth	/	4 H/c	Nil					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Furnace					
6	Material Sent For Hardening On Date		18	10	24				

Inspected By (Sign) & Date

Ravi 18/10/24

Sotya 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA