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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.		13052	45/60
2	Machined By		V.T.L. n/c Shop	Drg No. 18.02586
3	Pallet Die No.		13167 (3.5)	Recess
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	78mm Step 00.8018mm	Tabber 210
6	Inside Diameter	Drg. No.	66.012mm	Step length 30
7	Width of Pellet Die	Drg. No.	29mm	Width of 11mm
8	Grooves as per Drawing	Drg. No.	27x8x7.5mm 27x8x7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		78mm	
13	Tapping Hole Diameter		M22 M22 Check by M22 Bolt	Tapping No. of Holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29.3mm	Tapping Depth 27.4
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	4.0mm	Outside (3-3)	Inner					Row = 48
3	External Relief Depth		28mm	15mm					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		19	10	24				

Inspected By (Sign) & Date

Ravi 18/10/24

Satya 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA