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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13013	39/50
2	Machined By		V.T.L. n/c Shop	Drg No. (3.5) 872
3	Pallet Die No.		13061 (3.5) n/c	Rev: 00
4	Die Category	Drg. No.	9x draw die	
5	Out Side Diameter	Drg. No.	620.2 n/c	Step OD: 620.2 n/c
6	Inside Diameter	Drg. No.	520.12 n/c	Step length: 15.53
7	Width of Pellet Die	Drg. No.	222 n/c	Undercut: 1 n/c
8	Grooves as per Drawing	Drg. No.	11x10x5 n/c / 11x10x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	Tapping No. of Holes: 12
14	Tapping On Second Side	Half pitch of 1st side	ok	Bolt Side
15	Tapping Hole Depth		Drill Depth: 22.3 n/c	Tapping Depth: 22.5
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							Rev: 35
2	External Relief Dia	4.0 n/c	outside (3.3)		Inner				
3	External Relief Depth		18 n/c		11 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Comore
6	Material Sent For Hardening On Date		18	10	24				

Inspected By (Sign) & Date

Ravi 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA