

8443



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.		13183	50/55
2	Machined By		V. T. L. n/c Shop	Dy. No. 120/1331
3	Pallet Die No.		12222 (B.O) ✓	Rev. No. ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm ✓ Step 002 491mm	Step length 17.4mm ✓
6	Inside Diameter	Drg. No.	420.12 mm ✓	
7	Width of Pellet Die	Drg. No.	158 mm ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 mm / 12x8x3 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes & Both Side
12	Tapping PCD		454 mm ✓	
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 mm Tapping Depth 18.5 mm ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 29/10/24

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
Low 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	6.5 mm ✓	Outside (2.2)		Inner		
3	External Relief Depth		11 mm ✓		5 mm ✓		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Ramesh		
6	Material Sent For Hardening On Date		29	10	24		

Inspected By (Sign) & Date

Ravi 29/10/24

29/10/24

Reviewed by (Engineer-CNC)

Manager-QA