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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.			
2	Machined By		13134	80/80
3	Pallet Die No.		V.T.G H/c Shop	Drill No. L.S.O. 990
4	Die Category	Drg. No.	13519 (3-5)mm	Rev. 00
5	Out Side Diameter	Drg. No.	Jumbo	
6	Inside Diameter	Drg. No.	790mm Step OD: 743.5mm	Tapper 20°
7	Width of Pellet Die	Drg. No.	630.12mm	Step Length 23
8	Grooves as per Drawing	Drg. No.	265mm	
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5mm / 15x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685mm	Tapping No. of Holes: 16 Both Side
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 20.3mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 5/11/24

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 - 1 Hole Colored (A)

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

1	Counter Sinking Depth & Finish	ok								Rep = 42	
2	External Relief Dia								No - Relief		
3	External Relief Depth										
4	Inspection Done Before Hardening By (Name)								Ravi		
5	Material Sent For Hardening By (Name)								Keshav		
6	Material Sent For Hardening On Date								5	11	24

Inspected By (Sign) & Date Ravi 5/11/24

Ravi 5/11/24
Reviewed by (Engineer-CNC)

Manager-QA