

8482



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.		13196	34/50
2	Machined By		V.T.C n/c Shop	Drg No. Lark 3370
3	Pallet Die No.		13377 (4.0)	
4	Die Category	Drg. No.	Cent. sawside	
5	Out Side Diameter	Drg. No.	619.9mm, Step 002 611.9mm	Step length 12.4
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
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 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20, Check by n/c Bul	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/11/24

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

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	4.5mm	20 Side 3.3	Inner					
3	External Relief Depth		20mm	16mm					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		6	11	24				

Inspected By (Sign) & Date

Ravi 6/11/24

Sats 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA