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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.		13387	210/50
2	Machined By		V.T.L. H/c Shop	Drill No. 13.02.450
3	Pallet Die No.		12754 (4.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730 H/c	Step 00 = 742.4 H/c
6	Inside Diameter	Drg. No.	630.12 H/c	Tabber 1.10
7	Width of Pellet Die	Drg. No.	290 H/c	Step length 28.4
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c	Under coat = 6.75
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		N/c Shop	Tapping No. of Holes .16 Both Side
13	Tapping Hole Diameter		685 H/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 H/c	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 20/11/24

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

1	Counter Sinking Depth & Finish	ok					Counter 2-60
2	External Relief Dia	4.5 H/c	Outside (3-3)		Inner		Rev. 43
3	External Relief Depth		14 H/c		10 H/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark For more
6	Material Sent For Hardening On Date		30	11	24		

Inspected By (Sign) & Date

Ravi 20/11/24

Satyam 21/12/24

Reviewed by (Engineer-CNC)

Manager-QA