

8664



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.		13410	26/10
2	Machined By		V.T.L. n/a Shop	Drg No. 1.3.0.905
3	Pallet Die No.		12708(3.0) n/a	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/a, Step 00.491 n/a	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 n/a	
7	Width of Pellet Die	Drg. No.	158 n/a	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/a 12x8x3 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping No. of holes B Both side
12	Tapping PCD		454 n/a	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 n/a	Tapping Depth 16.6 n/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/11/24

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	3.5 n/a	Outside (2-2)		Inner				
3	External Relief Depth		10 n/a		4 n/a				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date				30	11	24		

Inspected By (Sign) & Date

Ravi 30/11/24

Reviewed by (Engineer-CNC)

Manager-QA