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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.		13521	30/40
2	Machined By		M.T.L. H/c Shop	Dy. Insp. Lark 3310
3	Pallet Die No.		12368 (3.2) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Step 00. 491 H/c	Step length = 17.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c 12 x 8 x 3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes - 8 Both Side
12	Tapping PCD		454 H/c	
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, 18.3 H/c	Tapping Depth, 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 2/12/24

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 60
2	External Relief Dia	3.8 H/c	Outside (2-2)		Inner				Row 2 23
3	External Relief Depth		13 H/c		10 H/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fornerce
6	Material Sent For Hardening On Date			2	12	24			

Inspected By (Sign) & Date Ravi 2/12/24

Reviewed by (Engineer-CNC) Satish 2/12/24

Manager-QA