

8682



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.		13426 ✓	40/50 ✓
2	Machined By		V.T.L. N/C Shop	Dy. N. L. P. 581
3	Pallet Die No.		10866 (8.8) N/C	Rev 00
4	Die Category	Drg. No.	M. Jamba	
5	Out Side Diameter	Drg. No.	700 N/C, Step OD, 700 N/C	Tapper = 12°
6	Inside Diameter	Drg. No.	600.12 N/C	Step length the 20 N/C
7	Width of Pellet Die	Drg. No.	222 N/C	Undercut = 1 N/C
8	Grooves as per Drawing	Drg. No.	14x8x7 N/C / 14x8x7 N/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping Holes of Holes 12 Bolt side
12	Tapping PCD		645 N/C	
13	Tapping Hole Diameter		H2 = Crack by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 N/C	Tapping Depth = 8.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/7/24

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 Closed (A)

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

Counter sink
 Rows 40

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	B.3 N/C	Outside (8-3)		Inner		
3	External Relief Depth		16 N/C		10 N/C		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		3	12	24		

Inspected By (Sign) & Date

Ravi 31/7/24

Reviewed by (Engineer-CNC)
 Satya 31/7/24

Manager-QA