

8706



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.			
2	Machined By		13594	35/50
3	Pallet Die No.		N.T.L n/c Shop	Digital Lock SS10
4	Die Category	Drg. No.	11457 (2.3) n/c	
5	Out Side Diameter	Drg. No.	Counterside	
6	Inside Diameter	Drg. No.	620 n/c	Step 002 812 n/c
7	Width of Pellet Die	Drg. No.	520.12 n/c	Step length 19.5
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c Check by n/c Ball	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 n/c	Tapping Depth 18.0
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 6/12/24

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						Counters 60°
2	External Relief Dia	3.1 n/c	outside @ 3-3		inner			60° 40
3	External Relief Depth		21 n/c		15 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			G	12	24		

Inspected By (Sign) & Date

Ravi 6/12/24

Reviewed by (Engineer-CNC)

Manager-QA