

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12636	60/70
2	Machined By		V.T.I. N/C Shop	Dy No. 12.0-861
3	Pallet Die No.		14038(3.5)M	Recess
4	Die Category	Drg. No.	S. Tombo	
5	Out Side Diameter	Drg. No.	1048 M, Step 002 to 33M	
6	Inside Diameter	Drg. No.	900.12 M	Tappers 3"
7	Width of Pellet Die	Drg. No.	375.3 M	Step length 37M
8	Grooves as per Drawing	Drg. No.	29.5x8x13 M / 29.5x8x13 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No of holes - 15 Both Side
12	Tapping PCD		970 M	
13	Tapping Hole Diameter		M242 Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 38.3 M	Tapping Depth 35.8 M
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 10/11/24	2 Slot
1	As per programme no.			39.1 M width
2	Gun Drilling Work Completed On			7.5 M Resp
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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 Recess = 59
2	External Relief Dia	4.0 M	Outside (U-U)	
3	External Relief Depth		17 M	Inner 10 M
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		16 12 24	
Inspected By (Sign) & Date			Ravi 10/11/24	

Reviewed by (Engineer-CNC)

Manager-QA