

8839



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		13668	30/45
3	Pallet Die No.		V.T.L H/C Shop	Drg No. 1.3.0-579
4	Die Category	Drg. No.	13668 (3.0) H/C	Rev. 01
5	Out Side Diameter	Drg. No.	Outside	
6	Inside Diameter	Drg. No.	610 H/C, Step 002 615.5 H/C	Tapper = 4°
7	Width of Pellet Die	Drg. No.	520.12 H/C	Step length 20 H/C
8	Grooves as per Drawing	Drg. No.	222 H/C	Under cut. 2.75 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/C / 13x8x5 H/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H/C	Tapping No. of holes 12 Both side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C Tapping Depth 18.5 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/12/24

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, 6°
2	External Relief Dia	3.5 H/C	Outside (3-3)		Inner			Rev. 38
3	External Relief Depth		15 H/C		9 H/C			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forpore
6	Material Sent For Hardening On Date		25	12	24			

Inspected By (Sign) & Date

Ravi 25/12/24

25/12/24

Reviewed by (Engineer-CNC)

Manager-QA