

8897



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		13604 ✓	50/55 ✓
3	Pallet Die No.		V.T.L n/c Shop	Drg No. 13021189
4	Die Category	Drg. No.	14090(4.5)mm ✓	Rev. 00 ✓
5	Out Side Diameter	Drg. No.	3210	
6	Inside Diameter	Drg. No.	530mm ✓ Step on 498.88mm ✓	Tapper 12°
7	Width of Pellet Die	Drg. No.	420.12mm ✓	Step length 18mm ✓
8	Grooves as per Drawing	Drg. No.	182mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping Holes of Both Side
13	Tapping Hole Diameter		454mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt ✓	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 18.2mm Tapping Depth 16.5mm ✓	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 26/12/24

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	5.0mm	outside (2-2)		Inner			Rev. 22
3	External Relief Depth		14mm		5mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		26	12	24			

Inspected By (Sign) & Date

Ravi 26/12/24

Reviewed by (Engineer-CNC)

Manager-QA