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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.		13758	45/56
2	Machined By		V.T.L N/C Shop	Dy. No. 18.0.320
3	Pallet Die No.		13784(3.0) N/C	Review
4	Die Category	Drg. No.	N. Jamba	
5	Out Side Diameter	Drg. No.	680.1 N/C Step 50 = 693 N/C	Tapper = 8"
6	Inside Diameter	Drg. No.	546.12 N/C (Boz = 548.3 N/C)	Step length 31.4 31.3 N/C
7	Width of Pellet Die	Drg. No.	195.3 N/C	Undercut = 2.3 N/C
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 N/C 30.3 x 7.9 N/C	(4 x 8) N/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	Gun Reap Both Side
11	Tapping Operator		N/C Shop	Tapping Ho
12	Tapping PCD		619 N/C	of holes = 2
13	Tapping Hole Diameter		N/C = Check by HIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.3 N/C	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/1/25	Final Fitting
1	As per programme no.		_____	Size = Dy
2	Gun Drilling Work Completed On		_____	No. 18.0.609
3	Hole Finish In Gun Drilling	Marked	ok	Review
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 Bore
2	External Relief Dia	9.0 N/C	All Rows	
3	External Relief Depth		21 N/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		13 / 1 / 25	
Inspected By (Sign) & Date			Ravi 13/1/25	

Reviewed by (Engineer-CNC) *[Signature]* 13/1/25

Manager-QA