

6343



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.		10586	210/40
2	Machined By		N.T.L. n/c Shop	Dy. n/c Lark SSTO
3	Pallet Die No.		10674 (410) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c, Step OD: 491 n/c	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
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 = 8 Both side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20 - Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 n/c	Tapping Depth: 16.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/10/23

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							
2	External Relief Dia	4.5 n/c	Outside 2-2		Inner				
3	External Relief Depth		4 n/c		Null				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		30	10	23				

Inspected By (Sign) & Date

Ravi 30/10/23

Reviewed by (Engineer-CNC)
S. Jyoti 30/10/23

Manager-QA