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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10453 ✓	38/50 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 18.0.415
3	Pallet Die No.		10866 (4.0) ✓	Revol ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 ✓ / Step 60 = 499 ✓	Tapper = 12°
6	Inside Diameter	Drg. No.	420.12 ✓	Step length = 20 ✓
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 ✓ / 12x8x3 ✓	
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 Back Side
12	Tapping PCD		454 ✓	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 ✓	Tapping Depth = 17.4 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/1/23

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							Ravi do
2	External Relief Dia	0.5 ✓	outside (2-2)		inner				
3	External Relief Depth		16 ✓		12 ✓				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		2	11	23				

Inspected By (Sign) & Date Ravi 31/1/23

Reviewed by (Engineer-CNC) 31/1/23

Manager-QA