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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.		10734 ✓	36/55
2	Machined By		V.T.L. n/c Shop	Drg. No. 1-80-114984
3	Pallet Die No.		11152 (8.0) ✓	Rev. 2.00 ✓
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	630 ✓ Step OD = 612 ✓	Step length = 19.5 ✓
6	Inside Diameter	Drg. No.	580.12 ✓	
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 ✓ / 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping n/c of hole, 12 Both Side
12	Tapping PCD		585 ✓	
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 = 21.2 ✓	Tapping Depth = 19 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 24/11/23

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								Rou. 18
2	External Relief Dia	8.5 ✓	outside (3-3)		Inner					
3	External Relief Depth		27 ✓		19 ✓					
4	Inspection Done Before Hardening By (Name)									Ravi ✓
5	Material Sent For Hardening By (Name)									Lark Ferrare
6	Material Sent For Hardening On Date		24	11	23					

Inspected By (Sign) & Date Ravi 24/11/23

Reviewed by (Engineer-CNC) [Signature] 24/11/23

Manager-QA