

6881



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.		10821	34/50
2	Machined By		V.T.L. n/c Shop	Dy. No. Lark 6355
3	Pallet Die No.		11093 (2.8) n/c	
4	Die Category	Drg. No.	Ext outside	
5	Out Side Diameter	Drg. No.	619.8 n/c Step 00, 612 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 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 12 Back side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.3 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/12/23

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 40
2	External Relief Dia	3.3 n/c	outside (3-3)		Inner				
3	External Relief Depth		22 n/c		16 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark furnace
6	Material Sent For Hardening On Date			9	12	23			

Inspected By (Sign) & Date

Ravi 9/12/23

Reviewed by (Engineer-CNC)
S. J. 9/12/23

Manager-QA