65.87

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.		10790	38/40 — 41.9
2	Machined By		V.T.L N/C Shop	Dy No. Lark 3310
3	Pallet Die No.		11517 (3.5) HH	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 HH, Step OD 395 HH, Step length 14.5	
6	Inside Diameter	Drg. No.	B to 12 HH	
7	Width of Pellet Die	Drg. No.	142 HH	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 HH / 15.5x7x2 dd	
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		355 HH	
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth, 21.3 HH Tapping Depth, 19 HH	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 11/12/23	
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						Rev. 13
2	External Relief Dia	3.3 HH	Outside (2-2)		Inner			
3	External Relief Depth		9 HH		2 HH			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		11	12	23			
	Inspected By (Sign) & Date		Ravi 11/12/23					

11/12/23

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner