65.86

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.		10730	34/40
2	Machined By		V.T.L M/c Shop	Dy No. Lark 9107 9810
3	Pallet Die No.		11513(3.0)MM	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400MM, Step OD: 395MM	Step length 4.5
6	Inside Diameter	Drg. No.	320.12MM	
7	Width of Pellet Die	Drg. No.	142 MM	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 MM / 15.5x7x2 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/c Shop	Tapping No of Holes 8 Both Side
12	Tapping PCD		355MM / 354.9MM	
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: 21.3MM	Tapping Depth = 19 MM
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						Raw - do
2	External Relief Dia	3.3MM	Outside (2-2)		Inner			
3	External Relief Depth		12MM		6MM			
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