

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

5258

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9839	
2	Machined By		V. T. C. n/c Shop	36/40
3	Pallet Die No.		9816 (3.2) n/c	Dy. No. L.R.O. 332
4	Die Category	Drg. No.	Senior	Rev. 02
5	Out Side Diameter	Drg. No.	500 n/c	
6	Inside Diameter	Drg. No.	Step 002 499 n/c	Tappet 12"
7	Width of Pellet Die	Drg. No.	420.12 n/c	Step length 20 n/c
8	Grooves as per Drawing	Drg. No.	158 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	Tapping No. of holes 8 Both side
13	Tapping Hole Diameter		n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c Check by n/c Bolt	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 16.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 6/7/23	
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	
2	External Relief Dia		3.5 n/c	Outside (2-2)
3	External Relief Depth		10 n/c	Inner 4 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Fornc	
6	Material Sent For Hardening On Date		6	7 23
Inspected By (Sign) & Date			Ravi 6/7/23	

Reviewed by (Engineer-CNC)

Manager-QA