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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.		11040 ✓	110/50 ✓
2	Machined By		V.T.L. 4/0 Stop	Drg. No. 1.2.C.125-1
3	Pallet Die No.		9987 (4.0) ✓	Rev. 01 ✓
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 ✓ / Side OD = 692.8 ✓	Tapper = 12°
6	Inside Diameter	Drg. No.	600.12 / 600.14 ✓	Step length = 19.8
7	Width of Pellet Die	Drg. No.	222 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x7 ✓ / 12x8x7 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Stop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 ✓	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4 ✓ Tapping Depth = 19 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 13/1/24

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				Counter 60°
2	External Relief Dia	4.5 ✓	outside (3-3)	inner		Rev. 32
3	External Relief Depth	✓	14 ✓	10 ✓		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		13	1	24	

Inspected By (Sign) & Date Ravi 13/1/24

Sarvesh
13/01/24
Reviewed by (Engineer-CNC)

Manager-QA