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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.		11107	27/47
2	Machined By		V.T.L. n/c Shop	1 Dy No. L:80/15431
3	Pallet Die No.		11462 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	Extenside	
5	Out Side Diameter	Drg. No.	614 n/c, Step OD = 611.8 n/c	Step length = 19.4
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	
12	Tapping PCD		565 n/c	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		n/c, Crack by H20 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 19/1/24

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 Kew = 38
2	External Relief Dia	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		93 n/c		20 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		19	1	24				

Inspected By (Sign) & Date: Ravi 19/1/24

Reviewed by (Engineer-CNC): Satya 19/1/24

Manager-QA