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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.		11277	35/40
2	Machined By		V.T.L. n/c Shop	Drg No. 1.20.95 67
3	Pallet Die No.		10989 (3.0) n/c	Rev. 01
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	5mm n/c Step 002 492.7mm	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	182.2 mm	
8	Grooves as per Drawing	Drg. No.	10x10x4mm / 10x10x4mm	
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		455 mm	
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: 18.7mm Tapping Depth: 16.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/8/24

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

Counter 65
Row 2 B0

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	3.5mm	outside (2-2)	inner		
3	External Relief Depth		1mm	5mm		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		16	2	24	

Inspected By (Sign) & Date

Ravi 16/8/24

Reviewed by (Engineer-CNC)

Manager-QA