

2056



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.		11361	53/58
2	Machined By		V.T.L. N/c Shop	Drg. No. L.E.C. 2986
3	Pallet Die No.		11939 (3.8) M4	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	77.6 M4 Step OD = 80 M4	Step length = 8 M4
6	Inside Diameter	Drg. No.	66.0/2 M4	86.3 M4
7	Width of Pellet Die	Drg. No.	316 M4	Width cut = 12 M4
8	Grooves as per Drawing	Drg. No.	20 x 8 x 7.5 M4 / 20 x 8 x 7.5 M4	
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 = 12 Both Side
12	Tapping PCD		72.5 M4	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 28 M4 Tapping Depth = 23.8 M4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/3/24

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 - 1 Hole Closed (A)

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	4.3 M4	80 Side (3-3)		Inner			Ravi = 47
3	External Relief Depth		12 M4		5 M4			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		5	3	24			

Inspected By (Sign) & Date

Ravi 5/3/24

Reviewed by (Engineer-CNC)

Manager-QA