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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9750	30/47/69
2	Machined By		V.T.I. w/a Shop	Drilling No. 1.5.02823
3	Pallet Die No.		10854 (G.O) M	Rev 2.0
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	838 M Step 0.02 848 M	Tapker, 5
6	Inside Diameter	Drg. No.	700.12 M	Step length 38.5
7	Width of Pellet Die	Drg. No.	240 M	Under cut 0.4 M
8	Grooves as per Drawing	Drg. No.	29x10x8 M 29x10x8 M (G.O) M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Groove 1 M Deep Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of holes 2
12	Tapping PCD		765 M	Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 32.3 M Tapping Depth 30.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/7/23

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

Counter 12 30°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 M 7.0 M	6.5 M	All Lines	7.0 M	All Lines			Row 2 18
3	External Relief Depth		3.9 M		2.8				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Barma
6	Material Sent For Hardening On Date		29	7	23				

Inspected By (Sign) & Date

Ravi 29/7/23

29/7/23

Reviewed by (Engineer-CNC)

Manager-QA