

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.		12207	40/55
2	Machined By		V.T.L. n/c Shop	Dy. No. 68.02.103
3	Pallet Die No.		12199 (8.0) n/c	Row 2
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	Ho n/c Step 02 692 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	36x107 7 n/c / 36x107 7 n/c	
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		645 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	Tapping Depth 18.5
15	Tapping Hole Depth		Drill Depth 20.4 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 25/6/24	
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 Row 13
2	External Relief Dia	9.0 n/c	All Rows	
3	External Relief Depth		15 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		25 6 24	
Inspected By (Sign) & Date			Ravi 25/6/24	

Satya
23/6/24

Reviewed by (Engineer-CNC)

Manager-QA