



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)

7061

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11441	29/50
2	Machined By		V.T.L H/c Shop	Dy. No. 1.8.029980
3	Pallet Die No.		11725(3.0)H	Rev. 2.00
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	6.20mm, Step OD, Tapper 12, Step length 18.5	
6	Inside Diameter	Drg. No.	5.20.12mm	
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes 12 Both side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		H2 = Check by Max Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 21mm Tapping Depth - 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/24

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 - 2 Hole Retosed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Count on 60
2	External Relief Dia	3.3mm	Outside (3.3)		Inner			Rev 2.38
3	External Relief Depth		17mm		11mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			6	3	24		

Inspected By (Sign) & Date

Ravi 31/24

Reviewed by (Engineer-CNC)

Manager-QA