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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.		11400	33/40
2	Machined By		V. T. L. H/C Shop	Drg No. Lark 5310
3	Pallet Die No.		11579 (3-0) H/C	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4mm H/C Step OD: 39.5mm	Step length: 14.5
6	Inside Diameter	Drg. No.	38.12 H/C	
7	Width of Pellet Die	Drg. No.	14.8 H/C	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/C	15.5 x 7 x 2 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of holes: 8 Both Side
12	Tapping PCD		35.5 H/C	
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: 21 H/C Tapping Depth: 18.8 H/C	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/3/24

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

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

Coorner: 60°
 Hole: 20

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5 H/C	outside (2-2)		Inner		
3	External Relief Depth		13 H/C		7 H/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		6	3	24		

Inspected By (Sign) & Date

Ravi 6/3/24

Sats 6/3/24

Reviewed by (Engineer-CNC)

Manager-QA