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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.		11372	36/40
2	Machined By		V.T.L. N/C Shop	Dy. H. S. 15-06-2013
3	Pallet Die No.		10967 (3.0) H/C	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C Step OD: 498	88 mm Tapper 12°
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 18mm
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C 12x8x3 H/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 = 2 Both side
12	Tapping PCD		454 H/C	
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: 19mm Tapping Depth: 17mm	
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

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	3.5 H/C	Outside (2-2)	Inner				Raw: 24
3	External Relief Depth		10mm	4mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Ferrace					
6	Material Sent For Hardening On Date		5	3	24			

Inspected By (Sign) & Date

Ravi 5/3/24

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Reviewed by (Engineer-CNC)

Manager-QA