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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.		11451	33/40
2	Machined By		V.T.L H/c Shop	Drg No. L.E.C 5069
3	Pallet Die No.		10972 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step 002 498.88 H/c	Tapping 12
6	Inside Diameter	Drg. No.	490.14 H/c	Step length 18 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 H/c 12.8 x 3 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		454 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.6 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 Raji 9/3/24

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 Counters G0

1	Counter Sinking Depth & Finish	ok								Row: 24
2	External Relief Dia	2.3 H/c	outside (2.2)		Inner					
3	External Relief Depth		13 H/c		7 H/c					
4	Inspection Done Before Hardening By (Name)									Raji
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			9	3	24				

Inspected By (Sign) & Date Raji 9/3/24

Satya
9/3/24
Reviewed by (Engineer-CNC)

Manager-QA