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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11451	36/40
2	Machined By		V. T. L. n/c Shop	Drg No. 1502
3	Pallet Die No.		10973 (4.0) n/c	Re 0200
4	Die Category	Drg. No.	M. K. K. Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step OD: 498.88 n/c	Tapped 12"
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 18 n/c
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 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 = 8 Both Side
12	Tapping PCD		454 n/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: 19 n/c	Tapping Depth: 17 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 7/3/24

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 0.2 Go
2	External Relief Dia	4.3 n/c	Outside (2-2)		Inner			
3	External Relief Depth		8 n/c		4 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Postage
6	Material Sent For Hardening On Date			7	3	24		

Inspected By (Sign) & Date Ravi 7/3/24

Reviewed by (Engineer-CNC) [Signature]

Manager-QA