

7079



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.		11417	45/45
2	Machined By		V.T.L. H/C Shop	Drg No. 13.0-511
3	Pallet Die No.		12078 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	610 H/C Step 002 612 H/C	Step length 19.8
6	Inside Diameter	Drg. No.	520.12 H/C	Under cut 1 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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 = 12 Rota Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M2 - Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 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 9/9/24

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° Lower 28
2	External Relief Dia	3.5 H/C	20 Side (3-3)		Inner		
3	External Relief Depth		4 H/C		Null		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date			9	3	24	

Inspected By (Sign) & Date Ravi 9/9/24

Reviewed by (Engineer-CNC) Sanyal 9/13/24

Manager-QA