

7075



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.		11401	40/50
2	Machined By		M. T. C n/c Shop	Drg No. L-30-405
3	Pallet Die No.		11931 (3.5) n/c	Rev. 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 n/c / Step 002 499 n/c	Tapper 12°
6	Inside Diameter	Drg. No.	420.12 n/c	Step length 16.8
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 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 28 Bottom Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0314" Check by 00314" Ball	
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 8/3/24

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 Counter: 600

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 n/c	Outside (2-2)	Inner					
3	External Relief Depth	17 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		8	3	24				

Inspected By (Sign) & Date Ravi 8/3/24

Sanyal
8/3/24
Reviewed by (Engineer-CNC)

Manager-QA