

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.		11291	48/50
2	Machined By		V.T.L H/c Shop	Py H/c 1.8.2013
3	Pallet Die No.		11396 (3.5) H/c	Rev 201
4	Die Category	Drg. No.	58370	
5	Out Side Diameter	Drg. No.	620.4 H/c Step CD = 623.4 H/c	Tapper = 12°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 2mm
7	Width of Pellet Die	Drg. No.	186 H/c	Under cut = 1.7 H/c
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c 13x8x3 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 Both Side
12	Tapping PCD		565 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 = 20.8 H/c	Tapping Depth = 18.3 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 11/3/24

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	6.0 H/c	outside 23-37	Inner				
3	External Relief Depth		15 H/c	8 H/c				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		11	3	24			

Inspected By (Sign) & Date Ravi 11/3/24

Satish
11/3/24

Reviewed by (Engineer-CNC)

Manager-QA