

7141



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.		11434	29/47
2	Machined By		V.T.L. n/c Shop	Drilling No. 1.9.02.15431
3	Pallet Die No.		11961 (2.8) n/c	Recd. 00
4	Die Category	Dr. No.	Extra wide	
5	Out Side Diameter	Dr. No.	614 n/c, Step 00 = 612 n/c	Step length = 19.4
6	Inside Diameter	Dr. No.	520.14 n/c	
7	Width of Pellet Die	Dr. No.	222 n/c	
8	Grooves as per Drawing	Dr. No.	13x8x5 n/c / 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 12 Both Sides
12	Tapping PCD		565 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 = 20.7 n/c	Tapping Depth = 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 19/3/24

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 G

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.1 n/c	Outside (3-3)	Inner					
3	External Relief Depth		20 n/c	18 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		19	03	24				

Inspected By (Sign) & Date

Ravi 19/3/24

Ravi 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA