

7138



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.		11016	60/65
2	Machined By		V.T.L. H/c Shop	Dy. No. 18.02.951
3	Pallet Die No.		12029 (4.5) H/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	549.9 H/c	Step 002, 49 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 174
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c	12 x 8 x 3 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 - 8 Bottom Side
12	Tapping PCD		454 H/c	
13	Tapping Hole Diameter		M20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 19.8 H/c	Tapping Depth: 17.5 H/c
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

1	Counter Sinking Depth & Finish	OK					Counter: 60
2	External Relief Dia	5.0 H/c	Outside (2-2)		Inner		Rev. 18
3	External Relief Depth	✓	14 H/c		5 H/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	3	24		

Inspected By (Sign) & Date

Ravi 19/3/24

Reviewed by (Engineer-CNC)
Sethi 19/3/24

Manager-QA