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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.		11488	40/40
2	Machined By		N.T.L. n/c Shop	Drg No. Lark STD 9/09
3	Pallet Die No.		11590 (4.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 n/c	Step 002 9.95 n/c Step length 14.5
6	Inside Diameter	Drg. No.	3.80.12 n/c	
7	Width of Pellet Die	Drg. No.	142 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c	15.5 x 7 x 2 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping Hole of Hole & Both Side
12	Tapping PCD		355 n/c	
13	Tapping Hole Diameter		M16 Clock by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth = 19 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 20/3/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								Raise 16
2	External Relief Dia	4.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth	✓	4 n/c		Nil					
4	Inspection Done Before Hardening By (Name)		✓	Ravi						
5	Material Sent For Hardening By (Name)			Lark Furnace						
6	Material Sent For Hardening On Date		20	03	24					

Inspected By (Sign) & Date Ravi 20/3/24

Reviewed by (Engineer-CNC) Ravi 20/3/24

Manager-QA