7170

Lark Engineering Company (India) Pvt. Ltd.	Form No.	CNC/QA/FM/02
I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)	Rev. No.	01
Inprocess Inspection (Pellet Dies)	Rev. Date	31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11503/.	31/40
2	Machined By		V.T.L m/c Shop	Dry Hon Lark 8199 8870
3	Pallet Die No.		11695 (3.0) HM	
4	Die Category	Drg. No.	SSD	
5	Out Side Diameter	Drg. No.	500 HM Step OD: 491 HM	Step length 17.4
6	Inside Diameter	Drg. No.	420.12 HM	
7	Width of Pellet Die	Drg. No.	18.9 HM	
8	Grooves as per Drawing	Drg. No.	12x8x3 HM / 12x8x3 HM	
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		M/C Shop	Tapping No of Holes: 8 Both Side
12	Tapping PCD		454 HM	
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: 19 HM	Tapping Depth: 17 HM
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	
	Inspected By (Sign) & Date		Ravi 22/3/24	
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						Counter: 60° Row: 30
2	External Relief Dia	3.3 HM	Outside (2.2)		Inner			
3	External Relief Depth		12 HM		9 HM			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		22	3	24			
	Inspected By (Sign) & Date		Ravi 22/3/24					

Reviewed by (Engineer-CNC) 22/3/24

Manager-QA

Scanned with CamScanner