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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11536	Bo/Bo
2	Machined By		V.T.L. H/C Shop	Dy H. 1.8.02 985
3	Pallet Die No.		11640 (5.0) H/C	Rev. 00
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	640 H/C, Step 002 621.5	Tappet 12°
6	Inside Diameter	Drg. No.	520.14 H/C	Step length 21.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x20x5 H/C 13x8x5 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 18.8 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/3/24

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							Count etc 60
2	External Relief Dia	5.5 H/C	Outside (2.3-3)		Inner				
3	External Relief Depth		10 H/C		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		23	3	24				

Inspected By (Sign) & Date

Ravi 23/3/24

Reviewed by (Engineer-CNC)

Manager-QA