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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.		11581 ✓	45/50
2	Machined By		V.T.L n/c Shop	Drill Hole 1.8-0.02 ✓
3	Pallet Die No.		11986(3.2) n/c ✓	Rev. 00
4	Die Category	Drg. No.	Feedrside	@
5	Out Side Diameter	Drg. No.	620.2 n/c ✓	Step 00.1 623.5 n/c ✓
6	Inside Diameter	Drg. No.	520.12 n/c ✓	Step length 1.8 n/c ✓
7	Width of Pellet Die	Drg. No.	222 n/c ✓	Under cut = 1.6 n/c ✓
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c ✓	13x8x5 n/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Back Side
12	Tapping PCD		565 n/c ✓	
13	Tapping Hole Diameter		n/c Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c ✓	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 1/4/24

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 6.5 Low = 37
2	External Relief Dia	3.8 n/c ✓	pos Side (3.3)		Inner			
3	External Relief Depth		1.2 n/c ✓		5 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			1	4	24		

Inspected By (Sign) & Date

Ravi 1/4/24

Satyam 1/4/24
Reviewed by (Engineer-CNC)

Manager-QA