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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.		11650	50/55
2	Machined By		V.T.L. H/C Shop	Drg No. L-3.02 436
3	Pallet Die No.		12155(8.2) H/C	Rev. 01
4	Die Category	Drg. No.	53810	
5	Out Side Diameter	Drg. No.	630 H/C, Step 0.02 612 H/C	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	186 H/C	
8	Grooves as per Drawing	Drg. No.	11.5 x 8 x 3 H/C / 11.5 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 = 12 Both side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		5/8 - Check by 5/8 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
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 3/4/24*

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 60
2	External Relief Dia	8.3 H/C	Outside (2-3)	Inner			Rev 2 15
3	External Relief Depth		13 H/C	5 H/C			
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>				
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>				
6	Material Sent For Hardening On Date		3	4	24		

Inspected By (Sign) & Date *Ravi 3/4/24*

Satya
31/4/24
Reviewed by (Engineer-CNC)

Manager-QA