

7246



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.		11584	36/50/6355
2	Machined By		V.T.C. H/C Shop	Dry run last 8.15
3	Pallet Die No.		11988 (3.0) H/C	
4	Die Category	Drg. No.	Extrawide	
5	Out Side Diameter	Drg. No.	620 H/C Step 00-612 H/C	Step length 194
6	Inside Diameter	Drg. No.	520.14 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 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 H/C of holes 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		M20.2 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/C Tapping Depth 8.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/4/24

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 Gun Row 2 38
2	External Relief Dia	3.3 H/C	outside (3-3)		Inner			
3	External Relief Depth		20 H/C		14 H/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		3	4	24			

Inspected By (Sign) & Date

Ravi 31/4/24

Reviewed by (Engineer-CNC)

Manager-QA