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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.		11640	38/43
2	Machined By		V. T. L. H/c Shop	Drg No. L3.02658
3	Pallet Die No.		11735 (3.0) H/c	Reo200
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	686 H/c, Step 00, 703 H/c	Step length = 23.5
6	Inside Diameter	Drg. No.	600.12 H/c	Tapper = 4°
7	Width of Pellet Die	Drg. No.	250 H/c	250 H/c
8	Grooves as per Drawing	Drg. No.	24x5x9 H/c 24x5x9 H/c	Under cut = 2.5 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		655 H/c	
13	Tapping Hole Diameter		H16 - Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25 H/c	Tapping Depth = 22.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/4/24

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						Counters 60° Ravi 24
2	External Relief Dia	3.5 H/c	outside (3-3)		inner			
3	External Relief Depth		11 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark For case
6	Material Sent For Hardening On Date			6	4	24		

Inspected By (Sign) & Date

Ravi 6/4/24

Satya 6/4/24

Reviewed by (Engineer-CNC)

Manager-QA