

7269



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.		11654 ✓	33/40 ✓
2	Machined By		V. T. L. M/c Shop	Dy. No. 630 332
3	Pallet Die No.		11312 (3.0) ✓	Rev. 02 ✓
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	500 ✓, Step 002 499 ✓	Tap hole 12 ✓
6	Inside Diameter	Drg. No.	420.14 ✓ @	Step length 20 ✓
7	Width of Pellet Die	Drg. No.	158.14 ✓	
8	Grooves as per Drawing	Drg. No.	1208 x 3 ✓ 1208 x 3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping Hole of holes 28 Bore Size
12	Tapping PCD		454 ✓	
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 19 ✓ Tapping Depth 17 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 8/4/24*

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 600 K02284
2	External Relief Dia	3.54 ✓	Outside (2-2)		Inner		
3	External Relief Depth		134 ✓		74 ✓		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		8	4	24		

Inspected By (Sign) & Date *Ravi 8/4/24*

Satya 8/4/24
Reviewed by (Engineer-CNC)

Manager-QA