

7257



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.		11683	24/40
2	Machined By		V.T.L. H/c Shop	Dy. M. Lark 9/09
3	Pallet Die No.		11583 (3.5) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/c	Step length = 11.5
6	Inside Diameter	Drg. No.	320.12 H/c	
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 2 Both Side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20 H/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 5/4/24

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	2.8 H/c	Outside (2-2)		Inner		
3	External Relief Depth		20 H/c		16 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		5	4	24		

Inspected By (Sign) & Date

Ravi 5/4/24

Reviewed by (Engineer-CNC)
Ravi 5/4/24

Manager-QA