

7279



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.		11161	40/53
2	Machined By		V. T. L. n/c Shop	Dry Hole 1.50 982
3	Pallet Die No.		19279 (8.0) mm	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	410 mm Step 002 384 mm	Step length 11 mm
6	Inside Diameter	Drg. No.	304.12 mm 304.4 mm	
7	Width of Pellet Die	Drg. No.	121 mm	
8	Grooves as per Drawing	Drg. No.	8.5 x 7 x 2 mm 8.5 x 7 x 2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 2 Batu Side
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		M12 Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 mm Tapping Depth 3.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/1/24

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 Sink 8
2	External Relief Dia	8.5 mm	outside (2-2)		inner		
3	External Relief Depth		17 mm		13 mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forance
6	Material Sent For Hardening On Date			8	4	24	

Inspected By (Sign) & Date

Ravi 8/1/24

Reviewed by (Engineer-CNC)

Manager-QA