

7294



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.		11285	50/35.5
2	Machined By		V.T.L n/c Shop	Dr. No. 1-20-902
3	Pallet Die No.		11158 (10.0) n/c	Rev 2.00
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	640.2 n/c Step 002 641.7 n/c	652.3 n/c
6	Inside Diameter	Drg. No.	508.4 n/c (A)	Step length 32 n/c
7	Width of Pellet Die	Drg. No.	175 n/c	Tappers 8° 3 n/c
8	Grooves as per Drawing	Drg. No.	30x21x8.2 n/c / 10x24 n/c	Under cut 0.8 n/c
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 - 4
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping (A) Shop	And Side 4 slot
15	Tapping Hole Depth		Drill Depth 30.8 n/c	Tapping Depth 98.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/1/24

4 slot
51.5 n/c long
28 n/c width
15 n/c Rch

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

Counters 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.0 n/c	All Rows						
3	External Relief Depth		15.5 n/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		8	4	24				

Inspected By (Sign) & Date

Ravi 21/1/24

Reviewed by (Engineer-CNC)

Manager-QA

On Date	Inspector	Counters 60
Ravi	Ravi	Ravi