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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.		11712	34/50
2	Machined By		V.T.L. H/C Shop	Dy. No. (2.0) 419
3	Pallet Die No.		11225 (4.0) H/C	200209
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/C Step OD 692 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12.5 x 8.0 7 H/C / 12.5 x 8.0 7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping dia of holes - 12 Back side
12	Tapping PCD		645 H/C	
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 22.8 H/C Tapping Depth 20.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 10/4/24

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 Bo
2	External Relief Dia	4.5 H/C	Outside (3.3)		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 Porroce
6	Material Sent For Hardening On Date		10	11	24		

Inspected By (Sign) & Date Ravi 10/4/24

Reviewed by (Engineer-CNC) Sats 10/4/24

Manager-QA