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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.		11345	37160
2	Machined By		V.T.L. H/c Shop	Drg No. 18-02854
3	Pallet Die No.		11565 (G.O) H/c	Rev 200
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c Step 60-692 H/c	Step length 19.4
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.	36x10x7 H/c / 36x10x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes. 12 Both 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 = 20.7 H/c Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/4/24

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° Row = 16
2	External Relief Dia	7.0 H/c	All Rows					
3	External Relief Depth		23 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		11	11	24			

Inspected By (Sign) & Date

Ravi 11/4/24

Satyam 11/4/24

Reviewed by (Engineer-CNC)

Manager-QA