

7299



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.		11727	38/40
2	Machined By		V. T. L. n/c Shop	Dry No 2 1.8 Cl 150G
3	Pallet Die No.		11292 (4.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c, Step 00-498.8 n/c	Tabber 2.12
6	Inside Diameter	Drg. No.	420.14 n/c (B)	Step length 1.2.8
7	Width of Pellet Die	Drg. No.	158.1 n/c	
8	Grooves as per Drawing	Drg. No.	120.8 x 3 n/c 112.8 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	[Tapping H. of Hole 2.8 Rate Side]
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M 20 = Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.8 n/c	Tapping Depth 17.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw 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							Count on 60
2	External Relief Dia	4.3 n/c	80 Side (2-2)		Inner				
3	External Relief Depth		8 n/c		4 n/c				
4	Inspection Done Before Hardening By (Name)								Raw
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date			11	4	24			

Inspected By (Sign) & Date

Raw 11/4/24

Reviewed by (Engineer-CNC)
Sats 11/4/24

Manager-QA