

7302



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.		11718	36/45/55
2	Machined By		V-T.L H/c Shop	Dy No. 13.9.12
3	Pallet Die No.		12143 (4.0) H	Rev 2.00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	H0 H H Step 00 G92 H	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H	
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H / 12.5 x 8 x 7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	
12	Tapping PCD		645 H	Tapping No. of Holes 2
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.7 H Tapping Depth 20.7	
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. 1 Hole Colored (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok					Counter Sinking	
2	External Relief Dia	4.5 H 5.0 H	4.5 H All Rows	5.0 H All Rows			Row 32	
3	External Relief Depth		19 H	10 H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Forname					
6	Material Sent For Hardening On Date		11	4	24			
Inspected By (Sign) & Date		<u>Ravi 11/4/24</u>						

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

Manager-QA