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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.		11673	45/50	
2	Machined By		V.T.L. H/c Shop	Drg. No. (C.S.O) 442	
3	Pallet Die No.		12261 (8.0) H/c	Rev. No.	
4	Die Category	Drg. No.	Senior		
5	Out Side Diameter	Drg. No.	520 H/c Step 00, 492 H/c	Step length 13.5	
6	Inside Diameter	Drg. No.	420.12 H/c		
7	Width of Pellet Die	Drg. No.	159 H/c		
8	Grooves as per Drawing	Drg. No.	7-7-7.5 H/c		
9	Fitting Sizes on CNC Plate	Drg. No.	7-7-7.5 H/c		
10	Drilling Area Surface Smoothness		ok		
11	Tapping Operator		H/c Shop		
12	Tapping PCD		455 H/c	Tapping H/c of Holes: 8 Both Side	
13	Tapping Hole Diameter		0314" = Check by 0314" Bolt		
14	Tapping On Second Side	Half pitch of 1st side	ok		
15	Tapping Hole Depth		Drill Depth: 22.7 H/c	Tapping Depth: 22.7	
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		ok		
Inspected By (Sign) & Date			Pass: 10/4/24		
1	As per programme no.			2 Slot 20.1 H/c width 7.1 H/c Depth Both Side	
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 Roz: 12	
2	External Relief Dia	8.5 H/c	Outside (2-2.7)	Inner	
3	External Relief Depth		13 H/c	5 H/c	
4	Inspection Done Before Hardening By (Name)		Pass		
5	Material Sent For Hardening By (Name)		Lark Furnace		
6	Material Sent For Hardening On Date		10	4	24
Inspected By (Sign) & Date			Pass: 10/4/24		

Reviewed by (Engineer-CNC)

Manager-QA