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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
Rev. Date	31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11781	3540
2	Machined By		V.T.L. H/c Shop	Drg No. (S.D) = 881
3	Pallet Die No.		11693 (3.0) H	Rev = 00
4	Die Category	Drg. No.	SRD	
5	Out Side Diameter	Drg. No.	500 H	Step 002 490.7 H
6	Inside Diameter	Drg. No.	420.12 H	Step length = 16.5
7	Width of Pellet Die	Drg. No.	173 H	
8	Grooves as per Drawing	Drg. No.	12x10x5 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		455 H	Tapping No. 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 = 20.8 H	Tapping Depth = 18.8 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/4/24

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						Counters 60
2	External Relief Dia	3.3 H	outside (2-2)		Inner			Rev = 27
3	External Relief Depth		10 H		4 H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			15	4	24		

Inspected By (Sign) & Date

Ravi 15/4/24

Reviewed by (Engineer-CNC)
Satsa 15/4/24

Manager-QA