

7322



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.		11734	19/40
2	Machined By		V. T. L. H/c Shop	Drg No. (1.3.0) 335
3	Pallet Die No.		11322 (2.8) H/H	Rev 200
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500.1 Step OD = 491.1 H/H	Step length = 7.5
6	Inside Diameter	Drg. No.	400.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H / 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H. of holes = 8 Both Side
12	Tapping PCD		454 H/H	
13	Tapping Hole Diameter		Ø314" = Check by Ø314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.8 H/H	Tapping Depth = 17 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 16/4/24

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 Counter = 65

1	Counter Sinking Depth & Finish	ok									
2	External Relief Dia	Ø.3 H/H	outside (2-2)		inner						
3	External Relief Depth		24 H/H		21 H/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			16	4	24					

Inspected By (Sign) & Date Ravi 16/4/24

Satya
16/4/24
Reviewed by (Engineer-CNC)

Manager-QA