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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.		11713	35/40
2	Machined By		V.T.L. H/C Shop	Drg H20 - 101k
3	Pallet Die No.		11316 (3.5) H/C	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/C, Step 02, 49 H/C	Step length 17.5
6	Inside Diameter	Drg. No.	49.12 H/C	
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/C 12 x 8 x 3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H20 of holes. 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.7 H/C	Tapping Depth: 7.3
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

1	Counter Sinking Depth & Finish	ok							Counter 2-85° Ravi 22
2	External Relief Dia	3.8 H/C	Outside (2-2)		Inner				
3	External Relief Depth		8 H/C		5 H/C				
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

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

Manager-QA