

7339



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.		11795	26/45
2	Machined By		V.T.L. n/c Shop	Dr. S. D. 2915
3	Pallet Die No.		12159 (3.0) n/c	Reo 200
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	610 n/c, Step 0.2 624 n/c	Step length 2mm
6	Inside Diameter	Drg. No.	520.12 n/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	186 n/c	Under cut 7mm
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		565 n/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 21 n/c Tapping Depth 18.8 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/4/24

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 60°
2	External Relief Dia	3.5 n/c	20 Side (3-3)	Inner			
3	External Relief Depth		22 n/c	19 n/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Parnore
6	Material Sent For Hardening On Date		18	4	24		

Inspected By (Sign) & Date

Ravi 18/4/24

Satish 18/4/24

Reviewed by (Engineer-CNC)

Manager-QA