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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.		11752	30/50
2	Machined By		N.T.L. n/c Shop	Drg. No. 13.0.119
3	Pallet Die No.		11231 (4.0) H4	Rev. 2.0
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H4	Step length 19.5
6	Inside Diameter	Drg. No.	600.12 H4	
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 H4	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		645 H4	Tapping No. of holes - 12
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	Depth Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.7 H4	Tapping Depth 20.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rasi 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

	Count on Gun	Count on 60
1 Counter Sinking Depth & Finish	OK	Row - 32
2 External Relief Dia	4.5 H4	
3 External Relief Depth	24 H4	
4 Inspection Done Before Hardening By (Name)	Rasi	
5 Material Sent For Hardening By (Name)	Lark Porrace	
6 Material Sent For Hardening On Date	18	4 24

Inspected By (Sign) & Date

Rasi 18/4/24

Reviewed by (Engineer-CNC)

Manager-QA