

7443



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.		11858	40/50
2	Machined By		V.T.L n/c Shop	Digital Mic 11858
3	Pallet Die No.		11650 (4.0) n/c	Rev. 02
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	6.20 n/c, Step 0.0, 6.24 n/c	Tapper 12
6	Inside Diameter	Drg. No.	5.20.12 n/c	Step length 13 n/c
7	Width of Pellet Die	Drg. No.	138 n/c	Width 12 n/c
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 depth of hole = 12 Back Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by M2 - Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/5/24

- 1 As per programme no.
- 2 Gun Drilling Work Completed On
- 3 Hole Finish In Gun Drilling
- 4 Defective Holes (If Any)

Marked

ok

No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter G-2

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 n/c	outside (3-3)		inner				
3	External Relief Depth		14 n/c		10 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Ramace				
6	Material Sent For Hardening On Date				6	5	24		

Inspected By (Sign) & Date

Ravi 01/5/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner