

7473



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.		11869	98/40
2	Machined By		V.T.C. H/C Shop	Drg. H/C Lark 3199
3	Pallet Die No.		11689 (2.8) H/C	
4	Die Category	Drg. No.	320	
5	Out Side Diameter	Drg. No.	500.1 H/C Step 002 491 H/C	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	12+8+3 H/C 12+8+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 H/C of Lark 3199 Baku Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H202 Check by H20 B...	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 19 H/C	Tapping Depth: 17 H/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 13/5/24

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 - 1 Hole Closed

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

Counter = 600

1	Counter Sinking Depth & Finish	OK							Row 2 31
2	External Relief Dia	3.3 H/C	20 Side (2.2)		Inner				
3	External Relief Depth		15 H/C		12 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			13	5	24			

Inspected By (Sign) & Date

Ravi 13/5/24

Satish 13/5/24

Reviewed by (Engineer-CNC)

Manager-QA