

7467



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.		11920	30/48
2	Machined By		V.T.C. H/A Shop	Dig. No. 180-208
3	Pallet Die No.		12118 (B.S.)	Rev. 2.00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	604 H/A, Step 002, 601.5 H/A	Tabber 212
6	Inside Diameter	Drg. No.	590.12 H/A	Step length 215
7	Width of Pellet Die	Drg. No.	222 H/A	Outer cut. 8.8 H/A
8	Grooves as per Drawing	Drg. No.	13x8x5 H/A 13x8x5 H/A	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	Tapping No. of holes 212 Rota Side
12	Tapping PCD		565 H/A	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/A	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 11/5/24	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Counter = 60 Row = 28
2	External Relief Dia	3.3 H/A	All Rows	
3	External Relief Depth		6 H/A	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11 5 24	
Inspected By (Sign) & Date			Ravi 11/5/24	

Reviewed by (Engineer-CNC)

Manager-QA