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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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11991	38/50/8/152
2	Machined By		V.T.C. HLC Shop	Dr. H. Lark 550
3	Pallet Die No.		11659 (3.2) HLC	
4	Die Category	Drg. No.	35570	
5	Out Side Diameter	Drg. No.	620 HLC Step 002 @ 12 mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 HLC	
7	Width of Pellet Die	Drg. No.	186 HLC	
8	Grooves as per Drawing	Drg. No.	13x8x5 HLC 13x8x5 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 HLC	
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 HLC	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/5/24

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 Colocal

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

1	Counter Sinking Depth & Finish	ok					Counter 26.0
2	External Relief Dia	3x8 HLC	outside (3-3)	Inner			Ravi 29
3	External Relief Depth		18 HLC	18 HLC			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		17	5	24		

Inspected By (Sign) & Date

Ravi 17/5/24

Reviewed by (Engineer-CNC)

Manager-QA