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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.		11974	32/40
2	Machined By		V. T. L. H/C Shop	Dy. No. 1.2.0.999 Lark 3300
3	Pallet Die No.		11679 (3.5) H/C	
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	500 H/C Shop 00. 491 H/C	Shop 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.	12x8x3 H/C 12x8x3 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 H. 100. 8 Both Side
12	Tapping PCD		4.54 H/C	
13	Tapping Hole Diameter		H200 Check by H200 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 H/C	Tapping Depth 17.4 H/C
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/5/24

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 200
2	External Relief Dia	4.0 H/C	outside (2.2)		Inner		Row 27
3	External Relief Depth		1.2 H/C		2 H/C		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Purvare
6	Material Sent For Hardening On Date		20	5	24		

Inspected By (Sign) & Date

Ravi 20/5/24

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Reviewed by (Engineer-CNC)

Manager-QA