

7509



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.		11901	34/40
2	Machined By		V.T.L. H/C Shop	Dy. No. 1502909
3	Pallet Die No.		11581 (3.0) H/C	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/C	
6	Inside Diameter	Drg. No.	Step OD: 395 H/C	Step length 4-5
7	Width of Pellet Die	Drg. No.	320.12 H/C	
8	Grooves as per Drawing	Drg. No.	143 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5 x 7 x 2 H/C	
10	Drilling Area Surface Smoothness	Drg. No.	ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping of holes 2-8 Back side
13	Tapping Hole Diameter		355 H/C	
14	Tapping On Second Side	Half pitch of 1st side	H/C Check by H/C Belt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 21 H/C	Tapping Depth: 19 H/C
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

1	As per programme no.		Ravi 16/5/24
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		ok

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

1	Counter Sinking Depth & Finish	ok						Counter 60°
2	External Relief Dia	13.3 H/C	60 Side (2.2)					Rev. 20
3	External Relief Depth		12 H/C		Inner			
4	Inspection Done Before Hardening By (Name)				6 H/C			
5	Material Sent For Hardening By (Name)							Ravi
6	Material Sent For Hardening On Date							Lark Furnace

Inspected By (Sign) & Date

Ravi 16/5/24

Reviewed by (Engineer-CNC)

Manager-QA