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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.		11919	45/50
2	Machined By		V.T.L. H/C Shop	Dy. H. I. E. G. 1376
3	Pallet Die No.		12265(-6.0) H/C	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 H/C, Side 00.49 H/C	Step length 7.5
6	Inside Diameter	Drg. No.	420.12 H/C	
7	Width of Pellet Die	Drg. No.	158 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 No. of Holes = 8 Both Side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		M2 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 19.8 H/C	Tapping Depth 7.4
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	
Note : Mark the defective holes/missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		OK	Counter, 6.0 Route 15
2	External Relief Dia		6.5 H/C	Outside (2-2) Inner
3	External Relief Depth		11 H/C	5 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Bussace	
6	Material Sent For Hardening On Date		17	5 24
Inspected By (Sign) & Date			Ravi 17/5/24	

Satya 17/5/24

Reviewed by (Engineer-CNC)

Manager-QA