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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.		11936	30/45/55
2	Machined By		V.T.L. H/C Shop	Drg No. 180412
3	Pallet Die No.		12194(4.5) H/C	Rev. No.
4	Die Category	Drg. No.	H-70mm	
5	Out Side Diameter	Drg. No.	70mm	Step 0.2 6.9mm
6	Inside Diameter	Drg. No.	600.12mm	Tabber 12
7	Width of Pellet Die	Drg. No.	222mm	Step length 2mm
8	Grooves as per Drawing	Drg. No.	14x8x7mm / 14x8x7mm	
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 - 12 Both Side
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M2x2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 22.8mm	Tapping Depth 22.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 15/5/24

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

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1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	5.0mm / 5.5mm	5.0mm	11 Rows	5.5mm	11 Rows			
3	External Relief Depth	/	3.5mm		1.0mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		15	5	24				

Inspected By (Sign) & Date

Ravi 15/5/24

Reviewed by (Engineer-CNC)
Sats 15/5/24

Manager-QA