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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.		11988	39/59
2	Machined By		V.T.L. n/c Shop	Dry H=1.8.0. 549
3	Pallet Die No.		12198 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	704 n/c, Step 00, 693 n/c, Tappers 12	
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 20 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c 12x10x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping H=1.8.0. of Hole 2.12 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rao: 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 26°
2	External Relief Dia	3.5 n/c	Outside (3.3)		Inner			Rev 2.38
3	External Relief Depth		19 n/c		13 n/c			
4	Inspection Done Before Hardening By (Name)							Rao:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		17	5	24			

Inspected By (Sign) & Date

Rao: 17/5/24

Reviewed by (Engineer-CNC)

Manager-QA