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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.		11783	31/07
2	Machined By		V.T.L. H/A Shop	Dg No. 139-547
3	Pallet Die No.		13197 (3.0) H/A	Rev. 01
4	Die Category	Dr. No.	H- Jumbo	
5	Out Side Diameter	Dr. No.	704 H/A, Step 002 693 H/A	Tap hole 12
6	Inside Diameter	Dr. No.	600.12 H/A	Step length 2mm
7	Width of Pellet Die	Dr. No.	222 H/A	
8	Grooves as per Drawing	Dr. No.	12 x 10 x 7.5 H/A 13 x 10 x 7.5 H/A	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	
12	Tapping PCD		640 H/A	Tapping H/A of holes - 12 Done side
13	Tapping Hole Diameter		M2 - Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.8 H/A	Tapping Depth 2.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/5/24

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 9
2	External Relief Dia	3.5 H/A	Outside (3-3)		Inner			Loop 28
3	External Relief Depth		19 H/A		13 H/A			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		16	5	24			

Inspected By (Sign) & Date

Ravi 16/5/24

Sot...
 16/5/24
 Reviewed by (Engineer-CNC)

Manager-QA