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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.		12404	35/55
2	Machined By		V.T.C. n/c Shop	Drg No. 1.30.755
3	Pallet Die No.		11444 (4.5)mm	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	737mm, Step OD, 754.3mm	Tapper 2.10
6	Inside Diameter	Drg. No.	630mm, 180Y 2627MM	Side length 29mm
7	Width of Pellet Die	Drg. No.	256mm	Under cut: 8.65
8	Grooves as per Drawing	Drg. No.	19.5 x 10 x 8 mm / 19.5 x 10 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes 2 Back Side
12	Tapping PCD		689mm	
13	Tapping Hole Diameter		M24 - Check by M24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth, 28.4mm	Tapping Depth 28.4mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 30/7/24*

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: 60 Ravi 231
2	External Relief Dia	5.0mm	20K side (3-3)	Inner				
3	External Relief Depth		25mm	20mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		30	7	24			

Inspected By (Sign) & Date *Ravi 30/7/24*

Reviewed by (Engineer-CNC) *Satyam 30/7/24*

Manager-QA