

5938



# 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.		10002	36/50
2	Machined By		V. T. G. N/C Shop	Drg No. L.E.C. 980
3	Pallet Die No.		10558 (3.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	620mm Step OD = Taper = 12 Step length = 18	
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm / 13x8x5mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C. Shop	
12	Tapping PCD		565mm	Tapping No. of holes 12 Bottom Side
13	Tapping Hole Diameter		M2x2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.0mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 12/8/23

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 - 5 Hole Closed (10)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5mm	outside (3-3)		inner				Ravi 98
3	External Relief Depth		dent		14mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			12	8	23			

### Inspected By (Sign) & Date

Ravi 12/8/23

Reviewed by (Engineer-CNC)

Manager-QA