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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.		12869	53/58
2	Machined By		V.T.L n/c Shop	Dr. No. L. S. C. 26
3	Pallet Die No.		13018 (3.8) n/c	Rev 2 00
4	Die Category	Drg. No.	Tumbo	
5	Out Side Diameter	Drg. No.	776 n/c	Step 00, 300 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	Step length = 25 n/c
7	Width of Pellet Die	Drg. No.	316 n/c	Under cut = 12 n/c
8	Grooves as per Drawing	Drg. No.	20x8x7.5 n/c	20x8x7.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	Ok	
10	Drilling Area Surface Smoothness		Ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Back Side
12	Tapping PCD		725 n/c	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	Ok	
15	Tapping Hole Depth		Drill Depth = 25.4 n/c	Tapping Depth = 23
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		Ok	

Inspected By (Sign) & Date

Ravi 18/9/24

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 - 1 Hole Closed

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

1	Counter Sinking Depth & Finish	Ok							Counter = 60
2	External Relief Dia	4.3 n/c	outside (3.3)	Inner					Row = 42
3	External Relief Depth		12 n/c	5 n/c					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		18	9	24				

Inspected By (Sign) & Date

Ravi 18/9/24

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Reviewed by (Engineer-CNC)

Manager-QA