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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.		10039	65/70
2	Machined By		V.T. L/C Shop	Drg No: L-8C-861
3	Pallet Die No.		5470 (4.0) mm	Rev 200
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1042 mm Step 602 1033 mm	Tapbers 3°
6	Inside Diameter	Drg. No.	900.12 mm	Step length 37 mm
7	Width of Pellet Die	Drg. No.	375 mm	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13.1 mm   29.5 x 8 x 13 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		970 mm	Tapping No of Holes = 15 Both Side
13	Tapping Hole Diameter		N24	
14	Tapping On Second Side	Half pitch of 1st side	Check by N24 Bolt	
15	Tapping Hole Depth		Drill Depth 38.3 mm	Tapping Depth 38.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/8/22

1	As per programme no.			2 Slot 32.1 mm width 7.5 mm Depth Both Side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No - 1 Hole Colused	

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

1	Counter Sinking Depth & Finish	ok							Ravi 253
2	External Relief Dia	4.5 mm	outside (4-4)		Inner				
3	External Relief Depth		13 mm		5 mm				
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	8	23				

### Inspected By (Sign) & Date

Ravi 16/8/23

Tarun 16/8/23

Reviewed by (Engineer-CNC)

Manager-QA