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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.		13340	40/48/55
2	Machined By		V.T.L. M/C Shop	Drg. No. 1.3.2-666
3	Pallet Die No.		13868 (B.O) M/C	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	70 M/C Step 00, 693 M/C	Tappet 12
6	Inside Diameter	Drg. No.	600.12 M/C	Step length 2.5 M/C
7	Width of Pellet Die	Drg. No.	222 M/C	
8	Grooves as per Drawing	Drg. No.	12 x 10 x 7.5 M/C   12 x 10 x 7.5 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		640 M/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: 20.4 M/C Tapping Depth: 18.0	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 30/11/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 M/C   7.0 M/C	6.5 M/C All Rows 2 15 M/C						
3	External Relief Depth		7.0 M/C All Rows 2 7 M/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		30	11	24				

Inspected By (Sign) & Date Ravi 30/11/24

Reviewed by (Engineer-CNC) Satyam 21/11/24

Manager-QA