

SB 25



# 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.		9280	45/60
2	Machined By		V.T.L h/c Shop	Dy No. ISD. 584
3	Pallet Die No.		10477 (8.0) H/H	Rev 201
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/H Step 100, 798 H/H / 792.1 H/H	Tapper = 4
6	Inside Diameter	Drg. No.	860.12 H/H	Step length = 25.5 H/H
7	Width of Pellet Die	Drg. No.	323.6 H/H	Undercut = 9 H/H / 86 H/H
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/H / 21.3 x 8 x 10 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		h/c Shop	Tapping No of holes = 12 Both Side
12	Tapping PCD		725 H/H	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 30.4 H/H Tapping Depth = 28.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 8/6/23

1	As per programme no.			2 Slot 32.1 H/H width 8 H/H Deep Both Side
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								Form 28
2	External Relief Dia	8.5 H/H	Outside 23-25		Inner					
3	External Relief Depth		23 H/H		15 H/H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Keshav
6	Material Sent For Hardening On Date		8	6	25					

### Inspected By (Sign) & Date

Ravi 8/6/23

Reviewed by (Engineer-CNC)

Manager-QA