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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.		13434	26/45/50
2	Machined By		V.T.L n/c Shop	Dr. H. 13.9.259
3	Pallet Die No.		13469 (4.0) n/c	Rev. 202
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	6.20 n/c, Step 002 6.23 n/c	Tapped 12°
6	Inside Diameter	Drg. No.	5.20.12 n/c	Step length 12 n/c
7	Width of Pellet Die	Drg. No.	22.2 n/c	Order cut 1.2 n/c
8	Grooves as per Drawing	Drg. No.	13x8x 5 n/c   13x8x 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 Both Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 10/12/24	
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.	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter 60° Row 231
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Rows 214 n/c	
3	External Relief Depth		5.0 n/c All Rows 25 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For work	
6	Material Sent For Hardening On Date		10 12 24	
Inspected By (Sign) & Date			Ravi 10/12/24	

Reviewed by (Engineer-CNC)

Manager-QA