

6274



# 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.		10157	19/66
2	Machined By		V.T.L n/c Shop	Qty No. 1.S.D. 609
3	Pallet Die No.		10899 (6.0) n/c	Rev 2 of 1
4	Die Category	Drg. No.	N-70 m/c	
5	Out Side Diameter	Drg. No.	680.69 n/c	Step OD = 693 n/c Tappet = 8°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length = 31 n/c
7	Width of Pellet Die	Drg. No.	195.1 n/c	Undercut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c	(4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step 2 n/c
10	Drilling Area Surface Smoothness		OK	Deep Both Side
11	Tapping Operator		N/c Shop	Tapping n/c
12	Tapping PCD		619 n/c	of Hole = 4
13	Tapping Hole Diameter		M16 = Check by M16 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Rept. 33.4 n/c	Tapping Depth 31.7 (A)
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 16/10/23

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 = 30

1	Counter Sinking Depth & Finish	OK							Rev 12
2	External Relief Dia	7.5 n/c	All Lines						
3	External Relief Depth		47 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		16	10	23				

Inspected By (Sign) & Date Ravi 16/10/23

Sohra  
16/10/23  
Reviewed by (Engineer-CNC)

Manager-QA