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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.		10149 to 10557 ✓	33/50 ✓
2	Machined By		V.T.L. n/c Shop	Drg. No. 1.3.0.2 ✓
3	Pallet Die No.		10570 (3.0) ✓	Rev. No. ✓
4	Die Category	Drg. No.	J&W	
5	Out Side Diameter	Drg. No.	730mm Step OD 743.4mm	Tap length 18mm ✓
6	Inside Diameter	Drg. No.	630.12mm	Step length 33mm ✓
7	Width of Pellet Die	Drg. No.	290mm	Under cut 6.75mm ✓
8	Grooves as per Drawing	Drg. No.	15x8x5mm / 15x8x5mm	
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 16 Both Side ✓
12	Tapping PCD		685mm ✓	
13	Tapping Hole Diameter		M202 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.8 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 18/10/23

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 - 2 Hole Closed (A)

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

1	Counter Sinking Depth & Finish	ok							8010258
2	External Relief Dia	3.3mm	Outside (3-3)		Inner				
3	External Relief Depth		23mm		17mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		18	10	23				

Inspected By (Sign) & Date Ravi 18/10/23

Satyam  
18/10/23

Reviewed by (Engineer-CNC)

Manager-QA