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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.		10241	38/50
2	Machined By		N.T.L. H/c Shop	Drg No. 2.0. 505
3	Pallet Die No.		10771 (3.5) H/H	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	730 H/H	Sd up 002 743 H/H
6	Inside Diameter	Drg. No.	630.12 H/H	Tabber = 4°
7	Width of Pellet Die	Drg. No.	255 H/H	Shop length 27.5
8	Grooves as per Drawing	Drg. No.	22x8x7 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	22x8x7 H/H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		685 H/H	
13	Tapping Hole Diameter		M22 - Check by M22 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 28.4 H/H	Tapping Depth 28.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Tapping No. of Holes 12 Both Side

Inspected By (Sign) & Date

Sanjeou 24/10/23

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

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	4.0 H/H	Outside (3-3)	Adjust (Line 3-3)	Inner	
3	External Relief Depth		20 H/H	16 H/H	12 H/H	
4	Inspection Done Before Hardening By (Name)		Sanjeou			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		24	10	23	

Inspected By (Sign) & Date

Ravi 24/10/23

Sanjeou 25/10/23

Reviewed by (Engineer-CNC)

Manager-QA