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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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10688	35/40
2	Machined By		V.T.L. N/C Shop	Dyno last 31/9
3	Pallet Die No.		10397 (3.5) H.H.	3510
4	Die Category	Drg. No.	3810	
5	Out Side Diameter	Drg. No.	500 H.H. - Step 00: 491 H.H.	Step length: 17.5
6	Inside Diameter	Drg. No.	420.12 H.H.	
7	Width of Pellet Die	Drg. No.	182 H.H.	
8	Grooves as per Drawing	Drg. No.	12x8x3 H.H.   12x8x3 H.H.	
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 = 8 Beta Side
12	Tapping PCD		454 H.H.	
13	Tapping Hole Diameter		M20: Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 18.4 H.H.	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ravi 21/11/23

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								Ravi 21/11/23
2	External Relief Dia	4.0 H.H.	Outside (2-2)		Inner					
3	External Relief Depth		8 H.H.		5 H.H.					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date									9 11 93

Inspected By (Sign) & Date Ravi 21/11/23

Reviewed by (Engineer-CNC) Sati 21/11/23

Manager-QA