6411

# 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. | | 10674 | 55/55 |
| 2 | Machined By | | V.T.L m/c Shop | Dy No. 130.407 Rev-00 |
| 3 | Pallet Die No. | | 11233 (4.0) HH | |
| 4 | Die Category | Drg. No. | M. Jambo | |
| 5 | Out Side Diameter | Drg. No. | 710 HH, Step OD = 692.8 HH Tapper 12° | |
| 6 | Inside Diameter | Drg. No. | 600.12 HH | Step length = 20 HH |
| 7 | Width of Pellet Die | Drg. No. | 222 HH | |
| 8 | Grooves as per Drawing | Drg. No. | 12 x 8 x 7 HH / 12 x 8 x 7 HH | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | Ok | |
| 10 | Drilling Area Surface Smoothness | | Ok | |
| 11 | Tapping Operator | | m/c Shop | Tapping No of holes. 12 Both Side |
| 12 | Tapping PCD | | 640 HH | |
| 13 | Tapping Hole Diameter | | M20 x Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | Ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 20.8 HH Tapping Depth = 19 HH | |
| 16 | Perpendicularity of Tapped Hole | | Yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | Inspected By (Sign) & Date | | Ravi 9/11/23 | |
| 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 3d |
| 2 | External Relief Dia | 4.5 HH | OD Side (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 5 HH | | Mill | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark Furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 9 | 11 | 23 | | | |
| | Inspected By (Sign) & Date | | Ravi 9/11/23 | | | | | |

Reviewed by (Engineer-CNC) 9/11/23

Manager-QA

Scanned with CamScanner