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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.		10641	40/40
2	Machined By		V.T.L. n/c Shop	Drill No. last 8810
3	Pallet Die No.		10707 (5.0) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Step OD = 49 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 n/c   420.14 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	120.8 x 3 n/c   12 x 8 x 3 n/c	
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 Bottom Side
12	Tapping PCD		454 n/c   453.9 n/c	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 19.8 n/c	Tapping Depth = 17.4 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/11/23

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							
2	External Relief Dia	5.5 n/c	outside (2-2)		Innen				
3	External Relief Depth		5 n/c		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		16		"	23			

Inspected By (Sign) & Date

Ravi 16/11/23

Reviewed by (Engineer-CNC)

Manager-QA