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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.		10710	38/50
2	Machined By		V. T. L. N/C Shop	Drg. No. = 1.8.0.998
3	Pallet Die No.		11066 (4.0)	Rev 00
4	Die Category	Drg. No.	9.5 sawide	
5	Out Side Diameter	Drg. No.	620.1mm, Step 002 Tapper, 12° Step length 18.5	
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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, 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		H20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8mm Tapping Depth 18.7	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 20/11/23

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								Rev. 31
2	External Relief Dia	4.5mm	Outside (3-3)		Inner					
3	External Relief Depth		16mm		12mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			20	11	23				

### Inspected By (Sign) & Date

Ravi 20/11/23

20/11/23

Reviewed by (Engineer-CNC)

Manager-QA