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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.		10538	30/55
2	Machined By		V.T.L n/c Shop	Drg No. 1-S.O-594
3	Pallet Die No.		11410 (6.0) mm	Rev. 00
4	Die Category	Drg. No.	5810	
5	Out Side Diameter	Drg. No.	530 mm	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 mm	
7	Width of Pellet Die	Drg. No.	182.1 mm	
8	Grooves as per Drawing	Drg. No.	1048 x 3 mm	1048 x 3 mm
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
12	Tapping PCD		454 mm	Both Side
13	Tapping Hole Diameter		0.314" - Check by 0.314" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.4 mm	Tapping Depth 16.8 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 23/11/23

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									Row = 19
2	External Relief Dia	6.5 mm	outside (2-2)		Inner						
3	External Relief Depth	✓	31 mm		25 mm						
4	Inspection Done Before Hardening By (Name)		✓	Ravi	✓						
5	Material Sent For Hardening By (Name)			Lark Furnace							
6	Material Sent For Hardening On Date		23	11	23						

**Inspected By (Sign) & Date**

Ravi 23/11/23

Sethi 23/11/23

Reviewed by (Engineer-CNC)

Manager-QA