

S752



# 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.		9788	55/60
2	Machined By		V. T. L. n/c Shop	Drg No. 1.8.02 584
3	Pallet Die No.		10446 (10.0) mm	Rec: ok
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Step OD = 798mm	Step length = 25.4
6	Inside Diameter	Drg. No.	660.12 mm	Under cuts 9mm
7	Width of Pellet Die	Drg. No.	324mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 mm / 21.5 x 24 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 = 12 Both Side
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4mm	Tapping Depth = 28.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/8/23	2 slot 32.1mm width 8mm Deep Both Side
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		10.5mm	both side (3-3)
3	External Relief Depth		10mm	Inner 5mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Forance	
6	Material Sent For Hardening On Date		4 7 23	
Inspected By (Sign) & Date			Ravi 4/8/23	

Reviewed by (Engineer-CNC)

Manager-QA