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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.		10529 ✓	45/55
2	Machined By		V.T.L. H/C Shop	By H.S.O. 407
3	Pallet Die No.		11376 (8.0) H/C	Recess
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	110 H/C / Step 00.690.9 H/C	Tabber: 12
6	Inside Diameter	Drg. No.	600.12 H/C	Step length: 20 H/C
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 13x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		640 H/C ✓	Tapping dia of holes = 12 Both Side
13	Tapping Hole Diameter		120. Check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 21 H/C Tapping Depth: 19 H/C	
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 20/12/23

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 18
2	External Relief Dia	9.5 H/C	outside (3-2)		Inner				
3	External Relief Depth		18 H/C		10 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Fornace
6	Material Sent For Hardening On Date		20	12	23				

**Inspected By (Sign) & Date**

Ravi 20/12/23

Satish 20/12/23

Reviewed by (Engineer-CNC)

Manager-QA