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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.		10883	32/39
2	Machined By		V.T. L n/c Shop	Drg No. 1.50.9 37
3	Pallet Die No.		8887 (3.2) mm	Reo = 00
4	Die Category	Drg. No.	MJEN	
5	Out Side Diameter	Drg. No.	678 mm Step OD = 692 mm	Step length = 22 mm
6	Inside Diameter	Drg. No.	600.12 mm	Under cut = 7 mm
7	Width of Pellet Die	Drg. No.	265 mm	
8	Grooves as per Drawing	Drg. No.	15x8x7 mm / 15x8x7 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 = 16 Both Side
12	Tapping PCD		640 mm	
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 = 21 mm Tapping Depth = 19 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 23/12/23

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					Counter = 60°
2	External Relief Dia	3.8 mm	outside	All four			Reo = 45
3	External Relief Depth			7 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	12	23	
Inspected By (Sign) & Date		Ravi 23/12/23					

Reviewed by (Engineer-CNC)

Manager-QA