

# 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/a Shop	Dr No. 1-2-2-584
3	Pallet Die No.		10447 (10.0) n/a	Rev 201
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 n/a	Step OD = 797.8 n/a
6	Inside Diameter	Drg. No.	660.12 n/a	Step length = 25.4
7	Width of Pellet Die	Drg. No.	323.8 n/a	
8	Grooves as per Drawing	Drg. No.	21.4 x 8 x 10 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 10 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		725 n/a	Tapping No of Holes = 12
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4 n/a	Tapping Depth = 28.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 6/7/23	
1	As per programme no.			2 Slot
2	Gun Drilling Work Completed On			32.1 n/a width
3	Hole Finish In Gun Drilling	Marked	ok	8 n/a Deep
4	Defective Holes (If Any)		No	Both Side
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		ok	Loop 19
2	External Relief Dia		10.5 n/a	Outside (2-3)
3	External Relief Depth		10 n/a	Inner 5 n/a
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		6 7 23	
Inspected By (Sign) & Date			Ravi 6/7/23	

Reviewed by (Engineer-CNC)

Manager-QA