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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.		10961	40/50
2	Machined By		V.T.L n/c Shop	Dy. No. 1.3.0.493
3	Pallet Die No.		9981 (8.0) n/c	Rev: 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c, Step 002 692.8 n/c	Tapper: 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length: 2 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c / 12x10x7.5 n/c	
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		640 n/c	
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: 20.4 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 4/1/23

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

Counter: 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	8.5 n/c	Outside (3-3)		Inner					
3	External Relief Depth		18 n/c		10 n/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date				4	1	23			

### Inspected By (Sign) & Date

Ravi 4/1/23

Reviewed by (Engineer-CNC)

Manager-QA