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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.		11045/	410/50/66/
2	Machined By		V.T. L.H.C. Shop	Drg No. 1-8.0.0.609
3	Pallet Die No.		11181 (B.O.) H.Y.	Rev 201/
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 H.Y. / Step OD = 698 H.Y.	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12 H.Y.	Step length = 31 H.Y.
7	Width of Pellet Die	Drg. No.	195 H.Y.	Under cut = 2.5 H.Y.
8	Grooves as per Drawing	Drg. No.	32x7x8 H.Y. / 32x7x8 H.Y.	(4x8) H.Y.
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Place Side step
10	Drilling Area Surface Smoothness		ok	Dark Both side
11	Tapping Operator		N/C Shop	Tapping Ho
12	Tapping PCD		619 H.Y.	of holes = 4
13	Tapping Hole Diameter		N/C = Check by N/C Bolt	Rock Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H.Y.	Tapping Depth = 30.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 5/1/24

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

Ground = 30°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 H.Y. / 7.5 H.Y.	6.5 H.Y. All Lines	7.5 H.Y. All Lines					
3	External Relief Depth	/	28 H.Y.	16 H.Y.					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		5	1	24				

Inspected By (Sign) & Date

Ravi 5/1/24

Reviewed by (Engineer-CNC)

Manager-QA