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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.		11040	110/50
2	Machined By		V.T.C. n/c Shop	Dy. No. L.F. 011936
3	Pallet Die No.		10527 (4.0) n/c	Rev. 02
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	320 n/c Step 00 - 624 n/c	Step length 12
6	Inside Diameter	Drg. No.	520.10 n/c	Tapper = 10°
7	Width of Pellet Die	Drg. No.	186 n/c	Under cot = 2 n/c
8	Grooves as per Drawing	Drg. No.	13 x 8 x 3 n/c   13 x 8 x 3 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		565 n/c	
13	Tapping Hole Diameter		n/c Check by n/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.8 n/c Tapping Depth = 18.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 10/1/24

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 Counter = 600

1	Counter Sinking Depth & Finish	ok							Ravi 25
2	External Relief Dia	4.5 n/c	outside (3-3)		Inner				
3	External Relief Depth	✓	14 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		10	1	24				

Inspected By (Sign) & Date Ravi 10/1/24

Reviewed by (Engineer-CNC) [Signature] 11/1/24

Manager-QA