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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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11092 ✓	40/45 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 62014949
3	Pallet Die No.		10489 (3.5) n/c ✓	Rev 2.00 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510 n/c ✓	Step 00 = 491 n/c ✓
6	Inside Diameter	Drg. No.	480.12 n/c ✓	Step length 12.4 ✓
7	Width of Pellet Die	Drg. No.	158.1 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12 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 = 8 Both Side
12	Tapping PCD		454 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 = 19.8 n/c ✓	Tapping Depth = 17.3 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/1/24

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 = 60

1	Counter Sinking Depth & Finish	ok							Low = 22
2	External Relief Dia	3.8 n/c ✓	outside (2-2)		Inner				
3	External Relief Depth		12 n/c ✓		5 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		13	1	24				

Inspected By (Sign) & Date

Ravi 13/1/24

Reviewed by (Engineer-CNC)

Manager-QA