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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.		11045	40/50/66
2	Machined By		V.T.L. n/c Shop	Dr. No. L.B.D. 2609
3	Pallet Die No.		11545 (6.0) n/c	Row = 12
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69 n/c Step 0.6 = 693 n/c	Step length = 31 n/c
6	Inside Diameter	Drg. No.	548.12 n/c	Tapper = 8°
7	Width of Pellet Die	Drg. No.	195 n/c	Under cot = 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 n/c / 32 x 7 x 8 n/c	Fore side step 2 n/c Back Both side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Tapping No. of holes = 4 Back side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 n/c Tapping Depth = 31.2	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 15/1/24

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 Counters 30° Row = 12

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	6.5 n/c / 7.5 n/c	6.5 n/c All Lines	7.5 n/c All Lines		
3	External Relief Depth		26 n/c	16 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		15	1	29	

Inspected By (Sign) & Date Ravi 15/1/24

Reviewed by (Engineer-CNC)

Manager-QA