

6287



# 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.		10946	42/55
2	Machined By		V. T. L. n/c Shop	Drg No. 1-3-02 412
3	Pallet Die No.		11577 (G.O) 44	Rev. No.
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 44 Step 002 692.8 44 Tappers 12°	
6	Inside Diameter	Drg. No.	600.12 44	Step length 19.8
7	Width of Pellet Die	Drg. No.	222 44	
8	Grooves as per Drawing	Drg. No.	14x8x7 44 / 14x8x7 44	
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 44	
13	Tapping Hole Diameter		420 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill 1 Rept 23.1 44 Tapping Depth 20.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 16/1/24

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							
2	External Relief Dia	6.5 44	outside (3-3)		Inner				
3	External Relief Depth		19 44		13 44				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		16	1	24				

**Inspected By (Sign) & Date**

Ravi 16/1/24

Reviewed by (Engineer-CNC)

Manager-QA