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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.		11028	98/45
2	Machined By		V.T.L. n/c Shop	Digital (S.O. 813
3	Pallet Die No.		10922 (2.8) n/c	Rev. 00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	404 n/c Step 00, 389 n/c	Step length 9.6 n/c
6	Inside Diameter	Drg. No.	315.12 n/c	
7	Width of Pellet Die	Drg. No.	145 n/c	
8	Grooves as per Drawing	Drg. No.	16x8x3 n/c   16x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping n/c of Holes 8 Both side
12	Tapping PCD		358 n/c	
13	Tapping Hole Diameter		0.314" = Check by 0.314" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 17/1/24

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

Count on 2 Go

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.3 n/c	20 Side (2-2)		Inner				
3	External Relief Depth		20 n/c		17 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			17	1	24			

**Inspected By (Sign) & Date**

Ravi 17/1/24

Satya 17/1/23

Reviewed by (Engineer-CNC)

Manager-QA