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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.		11198	50/66
2	Machined By		V.T.L. H/c Shop	60/66
3	Pallet Die No.		11480 (8.0) H/c	Drg No. 193.02.69
4	Die Category	Drg. No.	H-Jumbo	Revised
5	Out Side Diameter	Drg. No.	680.69 H/c	Step length 2 H/c
6	Inside Diameter	Drg. No.	548.12 H/c	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under ref = 2.4 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8.1 H/c	(4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step 5 H/c
10	Drilling Area Surface Smoothness		ok	Back Both side
11	Tapping Operator		H/c Shop	Tapping No of Holes = 4 Back Side
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		MIG = Check by MIG Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/c	Tapping Depth = 31.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 27/1/24

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 as 300

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	9.0 H/c	1st Pad	2nd Pad				
3	External Relief Depth		16 H/c	6 H/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		27	1	24			

**Inspected By (Sign) & Date**

Ravi 27/1/24

Reviewed by (Engineer-CNC)

Manager-QA