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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.		11172/	40/40
2	Machined By		V.T.L n/c Shop	Dr. No. I.S.O. 881
3	Pallet Die No.		10985 (3.0) n/c	Rev. 00
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	500 n/c, Step OD = 490.7 n/c	Step length 18.4
6	Inside Diameter	Drg. No.	480.12 n/c	
7	Width of Pellet Die	Drg. No.	173.1 n/c	
8	Grooves as per Drawing	Drg. No.	12x10x5 n/c / 12x10x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		455 n/c	Tapping No. of Holes = 8 Both side
13	Tapping Hole Diameter		0.34" = Check by 0.34" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 1.8 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 29/1/24

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

1	Counter Sinking Depth & Finish	ok						Counter 60°
2	External Relief Dia	3.5 n/c	outside 2-2.5		Inner			Ravi 29
3	External Relief Depth		6 n/c		Mill			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		29	1	24			

**Inspected By (Sign) & Date**

Ravi 29/1/24

Satish 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA