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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.		11120/	40/50/
2	Machined By		V.T.C H/c Shop	Dy No. = 1.850 195-1
3	Pallet Die No.		11205 (3.8) H/c	Rev 02 01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c Shop 602 692.8 H/c	Tapless 12
6	Inside Diameter	Drg. No.	600.12 H/c	Shop length 20 H/c
7	Width of Pellet Die	Drg. No.	222.2 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 H/c / 12 x 8 x 7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		640 H/c	[ Tapping No. of holes = 12 Both Side ]
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.4 H/c Tapping Depth = 18.8 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 24/1/24

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	4.3 H/c	outside (2-3)		Inner					
3	External Relief Depth		14 H/c		10 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			24	1	24				

**Inspected By (Sign) & Date**

Ravi 24/1/24

Reviewed by (Engineer-CNC)

Manager-QA