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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
Rev. Date	31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11037	53/55
2	Machined By		V.T.L.H/C Shop	Qty No 1.9.02 512
3	Pallet Die No.		11046 (3.8)H	Rev 02 09
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530H, Step 00, 491.1H, Step length	17.4
6	Inside Diameter	Drg. No.	420.12 H	
7	Width of Pellet Die	Drg. No.	158 H	
8	Grooves as per Drawing	Drg. No.	12x8x3H   12x8x3H	
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 8 Both side
12	Tapping PCD		454H	
13	Tapping Hole Diameter		03/4" = Crack by 03/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 19.8 H	Tapping Depth: 17H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 30/1/24

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

Counters 60

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.3H	outside (2-2)	Inner				
3	External Relief Depth		9H	2H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		30	1	24			

**Inspected By (Sign) & Date**

Ravi 30/1/24

Reviewed by (Engineer-CNC)

Manager-QA