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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.		11069	30/40/55
2	Machined By		N.T.L M/c Shop	Dry Hole 6-80 340
3	Pallet Die No.		11431 (B.0) M/c	Recessed
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	690 M/c, Step 002 681.5 M/c	Tapper 12°
6	Inside Diameter	Drg. No.	580.12 M/c	Step length 34.5
7	Width of Pellet Die	Drg. No.	266 M/c	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 M/c	28.5 x 6 x 12 M/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		NLC Shop	Tapping H of 12-12-12 Back Side
12	Tapping PCD		630 M/c	
13	Tapping Hole Diameter		M/C 2 Check by M/G Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 26.4 M/c	Tapping Depth 24
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

Counter 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 M/c	7.0 M/c	6.5 M/c	All Rows	7.0 M/c	All Rows		
3	External Relief Depth	/		2.5 M/c		1.5 M/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			30	1	24			

Inspected By (Sign) & Date

Ravi 30/1/24

Reviewed by (Engineer-CNC)

Manager-QA