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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.		11077	30/40/66 ✓
2	Machined By		V.T.L. n/c Shop	28/28/66 ✓
3	Pallet Die No.		11488 (G.O) n/c	Drg No. 1-3-0-609
4	Die Category	Drg. No.	M. Jumbo	Revol ✓
5	Out Side Diameter	Drg. No.	680.69 n/c Step 00-692.8 n/c	Tappers 8° ✓
6	Inside Diameter	Drg. No.	548.12 n/c	Step length 31 n/c ✓
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.4 n/c ✓
8	Grooves as per Drawing	Drg. No.	32x7x8 n/c   32x7x8 n/c (4-8) n/c	Face Side Step 2 n/c ✓
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Back Side ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No ✓
12	Tapping PCD		619 n/c	of holes 4 ✓
13	Tapping Hole Diameter		MIG : Check by MIG Bolt	Both Side ✓
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.7 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Rasi 9/8/24

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 30:

1	Counter Sinking Depth & Finish	OK	1st Pad 7.0 n/c	2nd Pad 7.0 n/c	3rd Pad 7.0 n/c	4th Pad 7.0 n/c	5th Pad 7.0 n/c	6th Pad 7.0 n/c	7th Pad 7.0 n/c	8th Pad 7.0 n/c	9th Pad 7.0 n/c	10th Pad 7.0 n/c	11th Pad 7.0 n/c	12th Pad 7.0 n/c	Counter 30:	
2	External Relief Dia	6.5 n/c   7.0 n/c	6.5 n/c	7.0 n/c	6.5 n/c	7.0 n/c	6.5 n/c	7.0 n/c	6.5 n/c	7.0 n/c	6.5 n/c	7.0 n/c	6.5 n/c	7.0 n/c	28 n/c	
3	External Relief Depth		2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c	2.5 n/c		
4	Inspection Done Before Hardening By (Name)		Rasi													
5	Material Sent For Hardening By (Name)		Lark Furnace													
6	Material Sent For Hardening On Date		9	9	9	9	9	9	9	9	9	9	9	9		

Inspected By (Sign) & Date Rasi 9/8/24

Reviewed by (Engineer-CNC)

Manager-QA