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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.		11387	22/45
2	Machined By		V.T.L n/c Shop	Drg No. 13.0.519
3	Pallet Die No.		11219 (2.8) n/c	Row 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	690mm, Step 00, 692mm	Step length 2mm
6	Inside Diameter	Drg. No.	600.12 mm	Undercut. 1mm
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	15x8x7mm   15x8x7mm	
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 = 12 Both Side
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		N20. Check by N20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8mm Tapping Depth 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/3/24

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 - 2 Hole Closed	Visual check by Jagan Sir

Visual check by Jagan Sir

Counter = 60 Row = 29

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	3.1mm	Outside (2-3)		Inner			
3	External Relief Depth		2mm		17mm			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Porrace			
6	Material Sent For Hardening On Date		9	3	24			

Inspected By (Sign) & Date

Ravi 9/3/24

Satish 9/3/24

Reviewed by (Engineer-CNC)

Manager-QA