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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.		11071	27/37/70
2	Machined By		V.T.L. n/c Shop	Drg No. 130-377
3	Pallet Die No.		10787 (G.5) n/c	Rev: 02
4	Die Category	Drg. No.	H. Tumbo	
5	Out Side Diameter	Drg. No.	688 n/c Step OD: 697.7 n/c	Tabber: 5°
6	Inside Diameter	Drg. No.	548.12 n/c	Step length: 28.5
7	Width of Pellet Die	Drg. No.	215 n/c	Under cut: 1.75 n/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 8 n/c / 29.5 x 10 x 8 n/c	(6 x 8) n/c
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: 2 Both Side
12	Tapping PCD		618 n/c	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 33 n/c Tapping Depth: 30 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 28/07

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

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1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	7.0 n/c / 7.5 n/c	7.0 n/c	All Rows	7.5 n/c	All Rows	
3	External Relief Depth			43 n/c		33 n/c	
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Purvace			
6	Material Sent For Hardening On Date		8	3	24		

**Inspected By (Sign) & Date**

Ravi 28/07/24

Satyam 28/07/24

Reviewed by (Engineer-CNC)

Manager-QA