7081

# 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. | | 11486 | 34/50 |
| 2 | Machined By | | V.T.L M/c Shop | Drg No. 1.8.0.450 |
| 3 | Pallet Die No. | | 11525 (2.8) MM | Rev 00 |
| 4 | Die Category | Drg. No. | 7&W | |
| 5 | Out Side Diameter | Drg. No. | 730 MM Step OD = 743.4 MM | Tapper = 10° |
| 6 | Inside Diameter | Drg. No. | 630.12 MM | Step length = 23 |
| 7 | Width of Pellet Die | Drg. No. | 290 MM | Under cut = 6.75 |
| 8 | Grooves as per Drawing | Drg. No. | 15x8x5 MM / 15x8x5 MM | |
| 9 | Fitting Sizes on CNC Plate | Drg. No. | ok | |
| 10 | Drilling Area Surface Smoothness | | ok | |
| 11 | Tapping Operator | | M/c Shop | Tapping No of holes. 16 Both Side |
| 12 | Tapping PCD | | 685 MM | |
| 13 | Tapping Hole Diameter | | M20 = Check by M20 Bolt | |
| 14 | Tapping On Second Side | Half pitch of 1st side | ok | |
| 15 | Tapping Hole Depth | | Drill Depth = 21 MM Tapping | Depth = 18.8 MM |
| 16 | Perpendicularity of Tapped Hole | | yes | |
| 17 | Visual Inspection Before Gun Drilling | | Ok | |
| | Inspected By (Sign) & Date | | Ravi 11/3/24 | |
| 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 — 1 Hole Colused | |

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

| | | | | | | | | |
|---|---|---|---|---|---|---|---|---|
| 1 | Counter Sinking Depth & Finish | Ok | | | | | | Raw = 53 |
| 2 | External Relief Dia | 3.1 MM | Outside (3-3) | | Inner | | | |
| 3 | External Relief Depth | | 22 MM | | 16 MM | | | |
| 4 | Inspection Done Before Hardening By (Name) | | Ravi | | | | | |
| 5 | Material Sent For Hardening By (Name) | | Lark furnace | | | | | |
| 6 | Material Sent For Hardening On Date | | 11 | 3 | 24 | | | |
| | Inspected By (Sign) & Date | | Ravi 11/3/24 | | | | | |

11/3/24

Reviewed by (Engineer-CNC)

Manager-QA

Scanned with CamScanner