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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.		11361	53/58
2	Machined By		V.T.L. n/c Shop	Dy No. L-2-C-986
3	Pallet Die No.		11940 (3-8) n/c	Rev = 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776 n/c / Step 002 800 n/c	Step length 90 n/c
6	Inside Diameter	Drg. No.	660.12 n/c	90 n/c
7	Width of Pellet Die	Drg. No.	318 n/c	Under cut = 12 n/c
8	Grooves as per Drawing	Drg. No.	20x8x7.5 n/c / 20x8x7.5 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
12	Tapping PCD		785 n/c	of holes = 12
13	Tapping Hole Diameter		M20 = Check by M20 B-11	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 28 n/c Tapping Depth 23.8 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 2/3/24

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

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

1	Counter Sinking Depth & Finish	ok						Counter 60° Law = 47
2	External Relief Dia	4.3 n/c	Outside (2-3)		Inner			
3	External Relief Depth		12 n/c		5 n/c			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Forance
6	Material Sent For Hardening On Date		2	3	24			

Inspected By (Sign) & Date

Ravi 2/3/24

Reviewed by (Engineer-CNC)

Manager-QA