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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.		11417	45/45
2	Machined By		V.T.L. M/c Shop	Dry No. 1.2.02 511
3	Pallet Die No.		18077 (3.0) M/c	Rev. No.
4	Die Category	Drg. No.	Get aside	
5	Out Side Diameter	Drg. No.	610 M/c Step OD, 612 M/c Step Length 19.5	
6	Inside Diameter	Drg. No.	520.14 M/c	Under cuts 1mm
7	Width of Pellet Die	Drg. No.	222 M/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 M/c / 13x8x5 M/c	
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. 12 Both Side
12	Tapping PCD		565 M/c	
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 = 20.7 M/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/3/24

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°
2	External Relief Dia	3.5 M/c	outside (2-3)		Inner		Part 38
3	External Relief Depth		4 M/c		Nil		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		21	3	24		

Inspected By (Sign) & Date

Ravi 21/3/24

Reviewed by (Engineer-CNC)

Manager-QA