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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

Rev. Date 31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11485	36/47
2	Machined By		v. T.C. H/C Shop	Dy. M. S.D. 990
3	Pallet Die No.		11223(3.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	✓
5	Out Side Diameter	Drg. No.	694 H/C Step 00 = 693 H/C Tapping	✓
6	Inside Diameter	Drg. No.	600.12 H/C	Step length 20.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	14x8x7 H/C / 14x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping no. of holes 12 Both Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		H202 Check by H202 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.8 H/C	Tapping Depth 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date		Ravi 20/3/24	
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 - Hole Closed (D)	

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	3.3 H/C	Outside (3-3)	Inner				Rev 2 38
3	External Relief Depth		17 H/C	11 H/C				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		20	3	24			

Inspected By (Sign) & Date		Ravi 20/3/24	
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viewed by (Engineer-CNC) 20/3/24

Manager-QA