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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.		11519	35/40
2	Machined By		V.T.L. n/c Shop	Dy. No. L.F. 02/5062
3	Pallet Die No.		11287 (3.5) n/c	Rev. no.
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c Shop 00-498.8 n/c	Tapper 12°
6	Inside Diameter	Drg. No.	420.14 n/c	Step length 123
7	Width of Pellet Die	Drg. No.	158.1 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c   12x8x3 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		454 n/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 19.8 n/c	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 22/3/24

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 Colored

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

Count = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.8 n/c	Outside (2.2)		Inner				
3	External Relief Depth		8 n/c		5 n/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		22	3	24				

**Inspected By (Sign) & Date**

Ravi 22/3/24

Reviewed by (Engineer-CNC)

Manager-QA