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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.		11885	38/40
2	Machined By		V.T.L. n/c Shop	Drg No. 1-B.02 400
3	Pallet Die No.		12185 (4.0) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 n/c, Step OD = 492 n/c	Step length 13.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	159 n/c	
8	Grooves as per Drawing	Drg. No.	7x7x5 n/c / 7x7x5 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 = 8 Both side
12	Tapping PCD		455 n/c	
13	Tapping Hole Diameter		Ø3/4" - Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.3 n/c	Tapping Depth 20.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 6/5/24

1	As per programme no.			2 Slot 20.1 n/c width 7 n/c Depth Both side
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

Counter, 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.3 n/c	Outside (2-2)		Inner					
3	External Relief Depth		6 n/c		2 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			6	5	24				

### Inspected By (Sign) & Date

Ravi 6/5/24

Sony 6/5/24

Reviewed by (Engineer-CNC)

Manager-QA