

7478



# 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.		11911	40/40
2	Machined By		N.T.L. N/C Shop	Qty Nos (I.S.D.) 977
3	Pallet Die No.		11814 (4.0) H4	Rev 201
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4, Step OD: 491 H4	Step length 13.5
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	159 H4	
8	Grooves as per Drawing	Drg. No.	1145 x 3 H4 / 1145 x 3 H4	
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		456 H4	
13	Tapping Hole Diameter		0.031" = Check by 0.031" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 17 H4 / Tapping Depth: 15 H4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 13/5/24

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					Counters = 6
2	External Relief Dia	4.5 H4	Outside (2-2)	Inner			
3	External Relief Depth		4 H4	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		13	5	24		

**Inspected By (Sign) & Date**

Ravi 13/5/24

Reviewed by (Engineer-CNC)

Manager-QA