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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.		11888	45/55
2	Machined By		N.T.L. n/c Shop	Dy No: 18.0.407
3	Pallet Die No.		18152 (8.0) n/c	Rev: 00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/c	Step OD = 693 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber = 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length 2 n/c
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c   12.3 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 n/c	Tapping No. of holes = 12
13	Tapping Hole Diameter		M20. Check by M20 Ball	Other side.
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 n/c	Tapping Depth = 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
<b>Inspected By (Sign) &amp; Date</b>				
1	As per programme no.			Rao: 15/5/24
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter = 18
2	External Relief Dia	8.5 n/c	outside (23-3)	
3	External Relief Depth		18 n/c	Inner 10 n/c
4	Inspection Done Before Hardening By (Name)			Rao
5	Material Sent For Hardening By (Name)			Lark Furnace
6	Material Sent For Hardening On Date		15	5 24
<b>Inspected By (Sign) &amp; Date</b>				
Rao: 15/5/24				

Reviewed by (Engineer-CNC)

Manager-QA