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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.		9809	45/60
2	Machined By		V.T.L. n/c Shop	Drg No. I.S.O. 843
3	Pallet Die No.		10983 (6.0) n/c	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	75.0 n/c Step 00, 742.7 n/c Tappers 47	
6	Inside Diameter	Drg. No.	630.12 n/c / 630.14 n/c	Step length, 27.5
7	Width of Pellet Die	Drg. No.	255 n/c	
8	Grooves as per Drawing	Drg. No.	22x8x7 n/c / 22x8x7 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 1.0.2.2.12 Both Side
12	Tapping PCD		685 n/c	
13	Tapping Hole Diameter		M22 Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth, 28.4 n/c	Tapping Depth, 28.2
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Rasi 25/8/23

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							Row 25
2	External Relief Dia	6.5 n/c	20.8 side (3-3)		Inner				
3	External Relief Depth	21 n/c			15 n/c				
4	Inspection Done Before Hardening By (Name)				Rasi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		25	7	25				

### Inspected By (Sign) & Date

Rasi 25/8/23

26/7/23

Reviewed by (Engineer-CNC)

Manager-QA