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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.		9785	45/51
2	Machined By		V.T.L n/c Shop	Drg No. L.S.O. 537
3	Pallet Die No.		10770 (3.5) n/c	Rev 2.00
4	Die Category	Drg. No.	M. Tumbo	
5	Out Side Diameter	Drg. No.	732 n/c Step OD = 743 n/c	Step length = 37.5
6	Inside Diameter	Drg. No.	630.12 n/c	Under cuts 5.5 n/c
7	Width of Pellet Die	Drg. No.	255 n/c	
8	Grooves as per Drawing	Drg. No.	22+8+7 n/c   22+8+7 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 = 12 Bot 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 = 28.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 25/7/23

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								Ravi 39
2	External Relief Dia	4.0 n/c	outside (3-3)		Inner					
3	External Relief Depth	✓	13 n/c		6 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			25	7	23				

Inspected By (Sign) & Date Ravi 25/7/23

Reviewed by (Engineer-CNC)

Manager-QA