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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.		9881	35/63/78
2	Machined By		V.T.L. n/c Shop	Dy No. 1.3.0.396
3	Pallet Die No.		10408 (6.0) n/c	Reorder
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	635.7 n/c / 632 Step 00, 635.3 n/c / 543 n/c	
6	Inside Diameter	Drg. No.	480.1 n/c / 489 n/c / 500 n/c	Step Length 26 n/c
7	Width of Pellet Die	Drg. No.	181.9 n/c	16.5
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 n/c / 27 x 12 x 8 x 9.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping Hole of holes 4
12	Tapping PCD		540 n/c	
13	Tapping Hole Diameter		MIG 2 Check by n/c	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Ind Side One Slot	
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			Ravi 24/7/23	1 Slot 28.1 n/c width 12 n/c Depth
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	Reorder 10
2	External Relief Dia	6.5 n/c / 7.0 n/c	6.5 n/c All Lines / 7.0 n/c All Lines	
3	External Relief Depth		43 n/c / 15 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Roshare	
6	Material Sent For Hardening On Date		24 / 7 / 23	
Inspected By (Sign) & Date			Ravi 24/7/23	

Reviewed by (Engineer-CNC) *[Signature]* 26/7/23

Manager-QA