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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.		12277	33/50
2	Machined By		V. T. L. N/C Shop	Dy. No. 13.2.15
3	Pallet Die No.		12129 (3.0) mm	Rev. No.
4	Die Category	Drg. No.	790	
5	Out Side Diameter	Drg. No.	730 mm Step 002 743.4 mm Step length 23	
6	Inside Diameter	Drg. No.	830.12 mm	Tapping to
7	Width of Pellet Die	Drg. No.	290 mm	Wider = 6.75 mm
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5 mm   15 x 8 x 5 mm	
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 - 16 Back Side
12	Tapping PCD		685 mm	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 3/7/24

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							
2	External Relief Dia	9.3 mm	Outside (2-3)	Inner					
3	External Relief Depth		23 mm	17 mm					
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		3	7	24				

### Inspected By (Sign) & Date

Ravi 3/7/24

Reviewed by (Engineer-CNC)  
Satoru 3/7/24

Manager-QA