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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.		12286	46/55
2	Machined By		V.T.L. n/c Shop	Dy. No. 12.0. 886
3	Pallet Die No.		12845 (10.0)	Revised
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 mm, Step OD: 624 mm	Tapping 12
6	Inside Diameter	Drg. No.	520.12 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13x8x3 mm   13x8x3 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, 12 Back Side
12	Tapping PCD		565 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: 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ravi 17/7/24

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						Counter 10
2	External Relief Dia	10.5 mm	Outside (23-3)	Inner				
3	External Relief Depth		11 mm	9 mm				
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							R.R
6	Material Sent For Hardening On Date		17	7	24			

**Inspected By (Sign) & Date**

Ravi 17/7/24

Reviewed by (Engineer-CNC)  
17/7/24

Manager-QA