



# 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.		13042	49/60
2	Machined By		V. TIL n/c Stop	Dy No. 180.539
3	Pallet Die No.		12912 (G.0) n/c	Rev: 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	820 n/c	Step 00. 823 n/c
6	Inside Diameter	Drg. No.	700.12 n/c	Tapper: 4°
7	Width of Pellet Die	Drg. No.	324 n/c	Step length: 33.1 n/c
8	Grooves as per Drawing	Drg. No.	30x8x7 n/c	Under cut: 1.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	30x8x7 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Stop	
12	Tapping PCD		760 n/c	Tapping No. of holes: 12 Both Side
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: 36 n/c	Tapping Depth: 34 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 22/10/24

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

Counter: 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	6.5 n/c	Outside (2.3)		Inner				
3	External Relief Depth		18 n/c		12 n/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		22	10	24				

### Inspected By (Sign) & Date

Ravi 22/10/24

Reviewed by (Engineer-CNC)

Manager-QA