



# 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)

8436

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13123	36/45
2	Machined By		V.T.L. H/O Shop	Drg. No. 12.0.2008
3	Pallet Die No.		13283 (B.O) H/O	Rev. no
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	510 H/O	Step length 19.5
6	Inside Diameter	Drg. No.	420.12 H/O	
7	Width of Pellet Die	Drg. No.	173 H/O	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	10 x 8.5 x 5 H/O	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		455 H/O	Tapping dia of Hole = 8 Both Side
13	Tapping Hole Diameter		Ø3/4" 2 Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 H/O	Tapping Depth: 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 25/10/24

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 H/O	Outside (2-2)		Inner					
3	External Relief Depth		15 H/O		9 H/O					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		25	10	24					

### Inspected By (Sign) & Date

Ravi 25/10/24

Reviewed by (Engineer-CNC)

Manager-QA