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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	Speciffcation	Observations	Remarks
1	Work Order No.		13460	30/50
2	Machined By		V.T.L n/c Shop	Dy. No. 1-202-998
3	Pallet Die No.		13010 (3.0) n/c	Rev 2.00
4	Die Category	Drg. No.	Carbide	
5	Out Side Diameter	Drg. No.	680 n/c	
6	Inside Diameter	Drg. No.	Step 0.2 Tabber 12°	
7	Width of Pellet Die	Drg. No.	52.12 n/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 n/c	[ Tapping n/c of holes 12 Both Side ]
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 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 4/12/24

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 - 1 Hole Colored (A)

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	3.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		23 n/c		20 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		4	12	24				

### Inspected By (Sign) & Date

Ravi 4/12/24

Reviewed by (Engineer-CNC)

Manager-QA