



# 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)

6006

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9903 to 10184	19/66 (19/66) 19/66
2	Machined By		V.T.C. N/C Shop	Drg No. 1.3.0-609
3	Pallet Die No.		10751 (6.0)mm	Rev 2.01
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.69mm Step OP-693mm	Tapper 2°
6	Inside Diameter	Drg. No.	548.12mm	Step length 20.8
7	Width of Pellet Die	Drg. No.	194.8mm	Width 2.5mm
8	Grooves as per Drawing	Drg. No.	31.9mm x 8mm   32.7mm x 8mm	(4.8)mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	face side step 2mm
10	Drilling Area Surface Smoothness		OK	Both Side
11	Tapping Operator		N/C Shop	Deep
12	Tapping PCD		619mm	Tapping No
13	Tapping Hole Diameter		N/C Check by N/C Bolt	of Hole 4
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.4mm Tapping Depth 31.2	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 28/8/23

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 2 30°

1	Counter Sinking Depth & Finish	OK								Rao 12
2	External Relief Dia	7.5mm	7.5mm	All Cires						
3	External Relief Depth			47mm						
4	Inspection Done Before Hardening By (Name)			Rao						
5	Material Sent For Hardening By (Name)			Lark Furnace						
6	Material Sent For Hardening On Date		28	8	23					

Inspected By (Sign) & Date

Rao: 28/8/23

Reviewed by (Engineer-CNC)

Manager-QA