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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.		10715	23/33/66
2	Machined By		V.T.L. n/c Shop	Drg No. 13.0.609
3	Pallet Die No.		11195 (6.0)mm	Ren=01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.69mm / Step OD = 692.8mm	Tapper = 8°
6	Inside Diameter	Drg. No.	548.12mm	Step length = 31mm
7	Width of Pellet Die	Drg. No.	195mm	Under cut = 2.5mm
8	Grooves as per Drawing	Drg. No.	32+7+8mm   32+7+8mm (4+8)mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2mm
10	Drilling Area Surface Smoothness		ok	Deep Both Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		619mm	of holes = 4
13	Tapping Hole Diameter		MIG 2 Check by MIG Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4mm	Tapping Depth = 31.6
16	Perpendicularity of Tapped Hole		yes	31.2
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 10/11/23

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

Counters 30

1	Counter Sinking Depth & Finish	ok							Ren=12
2	External Relief Dia	6.5mm / 7.0mm	6.5mm	All Lines	7.0mm	All Lines			
3	External Relief Depth		43mm			33mm			
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Formace
6	Material Sent For Hardening On Date		10	11	23				

### Inspected By (Sign) & Date

Ravi 10/11/23

Satyan 10/11/23

Reviewed by (Engineer-CNC)

Manager-QA