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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.		11062	2035/45
2	Machined By		V. T. L. H/c Shop	Drg No. 13.02492
3	Pallet Die No.		11142 (5.0) H/c	Recess
4	Die Category	Drg. No.	5 & 10	
5	Out Side Diameter	Drg. No.	510 H/c, Step OD = 491 H/c, Step length 12.4	
6	Inside Diameter	Drg. No.	420.14 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/c Shop	Tapping No. of Holes = 8 Both side
12	Tapping PCD		454 H/c	
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 = 19.8 H/c Tapping Depth = 17.2 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 13/1/24

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

1	Counter Sinking Depth & Finish	ok					Counter = 60° Ravi 21
2	External Relief Dia	5.5 H/c	outside (2-2)		Inner		
3	External Relief Depth		15 H/c		10 H/c		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Forwarc				
6	Material Sent For Hardening On Date		13	1	24		

### Inspected By (Sign) & Date

Ravi 13/1/24

*[Signature]*  
13/01/24

Reviewed by (Engineer-CNC)

Manager-QA