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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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11091	3140
2	Machined By		N.T.L. M/C Shop	Dy. No. Lark 2199
3	Pallet Die No.		8649 (3.5) M4	
4	Die Category	Drg. No.	S2M	
5	Out Side Diameter	Drg. No.	499.5 M4 Step 0.02 491 M4	Step length = 17.4
6	Inside Diameter	Drg. No.	490.12 M4	
7	Width of Pellet Die	Drg. No.	18.2 M4	
8	Grooves as per Drawing	Drg. No.	10x8x3 M4 / 10x8x3 M4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454 M4	
13	Tapping Hole Diameter		M2.2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.4 M4 Tapping Depth = 16.8 M4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 15/1/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter = 60°

1	Counter Sinking Depth & Finish	ok							Ravi 28
2	External Relief Dia	3.8 M4	outside (2-2)		Inner				
3	External Relief Depth		13 M4		9 M4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		15	1	24				

### Inspected By (Sign) & Date

Ravi 15/1/24

Reviewed by (Engineer-CNC)

Manager-QA