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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.		11057	36/46/60
2	Machined By		V.T.L. N/C Shop	Dry No. 1.3.0. 797
3	Pallet Die No.		11003 (4.0) 44	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 44 Step 00: 792 44	Step length 365
6	Inside Diameter	Drg. No.	660.14 44	Under cut 260
7	Width of Pellet Die	Drg. No.	324 44	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 44   21.5 x 2 x 3 44	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		725 44	[ Tapping no of holes = 12 ] Back Side
13	Tapping Hole Diameter		M20 Chack by n20 Belt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 324 44	Tapping Depth 398
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Rasi 16/1/24

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 - 2 Hole Closed / 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	4.5 44 / 5.0 44	4.5 44 All Rows	5.0 44 All Rows				
3	External Relief Depth		24 44	14 44				
4	Inspection Done Before Hardening By (Name)		✓ Rasi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		16	1	24			

### Inspected By (Sign) & Date

Rasi 16/1/24

Reviewed by (Engineer-CNC)  
16/1/24

Manager-QA