

6856



# 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.		11115	50/60
2	Machined By		V.T.L n/c Shop	Dry hole 1.52 409
3	Pallet Die No.		10198 (4.0) n/c	Reason
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	64.0 n/c Step 0.2 612.1 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	52.0 12 n/c	
7	Width of Pellet Die	Drg. No.	186 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 n/c 13x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping dia of Holes, 12 Bolt Side
12	Tapping PCD		56.5 n/c	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 91.4 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 28/1/24

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

Count of 60  
Row 25

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 n/c	Outside 23-25	Inner			
3	External Relief Depth		18 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		28	24			

Inspected By (Sign) & Date Ravi 28/1/24

Satish 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA