



# 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

6843

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11091	27/40
2	Machined By		V.T.L. H/c Step	Drg No: Task 9370
3	Pallet Die No.		11696 (3.2) H	
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	500 H Step OD = 49.1 H	Step length, 17.4
6	Inside Diameter	Drg. No.	49.1 H	
7	Width of Pellet Die	Drg. No.	18.2 H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H   12x8x2.5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Step	Tapping No of Holes = 8 Both side
12	Tapping PCD		45.4 H	
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 = 19.7 H Tapping Depth = 17.2	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 27/1/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.5 H	Outside (2-2)		Inner				
3	External Relief Depth		16 H		13 H				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		27	1	24				

### Inspected By (Sign) & Date

Ravi 27/1/24

Jahy 27/1/24

Reviewed by (Engineer-CNC)

Manager-QA