



# 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)

6863

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11084	50/55
3	Pallet Die No.		N.T.L. n/c shop	Dy. No. L-80, 18981
4	Die Category	Drg. No.	11413 (G.O) n/c Senior	Rev. 2.00
5	Out Side Diameter	Drg. No.	530.1 n/c	
6	Inside Diameter	Drg. No.	Step 00, 491. n/c	Step length 17.4
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	158.1 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c shop	Tapping No. of holes = 8 Both side
13	Tapping Hole Diameter		454 n/c	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Roll ok	
15	Tapping Hole Depth		Drill Depth = 18.8 n/c	Tapping Depth = 12 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 29/1/24

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	15
1	Counter Sinking Depth & Finish	ok	
2	External Relief Dia	6.5 n/c	Outside (2-2) Inner
3	External Relief Depth	11 n/c	5 n/c
4	Inspection Done Before Hardening By (Name)	Ravi	
5	Material Sent For Hardening By (Name)	Lark Formore	
6	Material Sent For Hardening On Date	29	1 24

### Inspected By (Sign) & Date

Ravi 29/1/24

29/1/24

Reviewed by (Engineer-CNC)

Manager-QA