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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.		11251	34/50
2	Machined By		V.T.I. n/c Shop	Dry No. 13.D. 633
3	Pallet Die No.		11393 (4.0) n/c	Revised
4	Die Category	Drg. No.	53370	(A)
5	Out Side Diameter	Drg. No.	620mm, Step 60 = 623.2mm	Step length 9mm
6	Inside Diameter	Drg. No.	520.12mm	Tapper 12
7	Width of Pellet Die	Drg. No.	186mm	Under cut 1.6mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm   13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21.4mm Tapping Depth 19mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 9/2/24

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	4.5mm	outside (3-3)		Inner					
3	External Relief Depth		20mm		16mm					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date			9	2	24				

Inspected By (Sign) & Date Ravi 9/2/24

Reviewed by (Engineer-CNC)

Manager-QA