



# 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)

6969

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11992	38/55
2	Machined By		V.T.L H/C Stop	Day No. 18.0
3	Pallet Die No.		11784 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	M. Tombo	
5	Out Side Diameter	Drg. No.	700 H/C Stop OD = 699.8 H/C	Tappes = 12
6	Inside Diameter	Drg. No.	600.12 H/C	Step long by 2mm
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/C / 12x8x7 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Stop	Tapping No. of Holes = 12 Beta Side
12	Tapping PCD		640 H/C	
13	Tapping Hole Diameter		M2x Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 81.4 H/C	Tapping Depth = 9mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 16/8/24

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

1	Counter Sinking Depth & Finish	ok							Counter Go
2	External Relief Dia	4.5 H/C	outside (3-3)		inner				Rev = 32
3	External Relief Depth		21 H/C		17 H/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Formace
6	Material Sent For Hardening On Date		16	2	24				

### Inspected By (Sign) & Date

Ravi 16/8/24

Satya 16/8/24

Reviewed by (Engineer-CNC)

Manager-QA