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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.		9899 to 11474	43/50
2	Machined By		V.T.L n/c Shop	Drg No. L.E.C-9980
3	Pallet Die No.		10626 (5.0) H	Rev 200
4	Die Category	Drg. No.	Ext outside	
5	Out Side Diameter	Drg. No.	620 H	Step OD 2 Tappes 12° Step length 18
6	Inside Diameter	Drg. No.	520.12 H / 520.14 H	
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H / 13x8x5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Hole of 4 holes 12° Rotn Side
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		N22 Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 H	Tapping Depth 8.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 11/3/24*

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					Counters 60° Rev 228
2	External Relief Dia	5.5 H	Outside (3-3)	Inner			
3	External Relief Depth		13 H	8 H			
4	Inspection Done Before Hardening By (Name)		<i>Ravi</i>				
5	Material Sent For Hardening By (Name)		<i>Lark Lorraine</i>				
6	Material Sent For Hardening On Date		1	3	24		

Inspected By (Sign) & Date *Ravi 11/3/24*

Reviewed by (Engineer-CNC)

Manager-QA