

7060



# 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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10561 to 11468	39/50
2	Machined By		V. T. L. N/A Shop	6355 Dy. No. Lark 8310
3	Pallet Die No.		10804 (3-5) H	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620 H, Step OD = 612 H	Step length dia = 194
6	Inside Diameter	Drg. No.	520.12 H	
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	1348 x 5 H / 1378 x 5 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No of Holes = 12 Both Side
12	Tapping PCD		565 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 = 21 H	Tapping Depth = 18.8 H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/3/24

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 - Hole Closed (D)

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	U.O.H	Outside (3-2)	Inner					
3	External Relief Depth		19 H	11 H					
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		6	3	24				

Inspected By (Sign) & Date

Ravi 6/3/24

*[Signature]*  
6/3/24

Reviewed by (Engineer-CNC)

Manager-QA