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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.		11018	60/65
2	Machined By		V. T. G. N/C Shop	Dr. No. 68.02 951
3	Pallet Die No.		12030 (4.5) H/H	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	549.8 H/H	Step 00 = 49 H/H - Step length 17.4
6	Inside Diameter	Drg. No.	420.14 B	
7	Width of Pellet Die	Drg. No.	158 H/H	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H   12x8x3 H/H	
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 = 8 Both Side
12	Tapping PCD		454 H/H   453.9 H/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 = 19.9 H/H	Tapping Depth = 17.6 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 19/3/24

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						Counter 60
2	External Relief Dia	5.0 H/H	outside (2-2)	Inner				
3	External Relief Depth		14 H/H	15 H/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		19	3	24			

Inspected By (Sign) & Date Ravi 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA