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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.		10603 to 11611	42/50
2	Machined By		V.T.L. M/C Shop	Drilling No. L.S. 02 715
3	Pallet Die No.		10852 (3.5) M/C	Row 2 of 6355
4	Die Category	Drg. No.	End guide	Final fitting 6355
5	Out Side Diameter	Drg. No.	620 M/C Shop 00, 620.5 M/C	Tapping 12
6	Inside Diameter	Drg. No.	520.14 M/C	Step length 2.5
7	Width of Pellet Die	Drg. No.	222 M/C	Under cut 0.25
8	Grooves as per Drawing	Drg. No.	13x2x5 M/C   13x2x5 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping No. of Holes 12 Back Side
12	Tapping PCD		565 M/C	
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 20.8 M/C	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ravi 23/3/24

Size  
Maintain  
After Hard

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 - 2 Hole Colored	

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter 60

1	Counter Sinking Depth & Finish	OK							Row 35
2	External Relief Dia	4.0 M/C	Outside (2-3)		Inner				
3	External Relief Depth		15 M/C		8 M/C				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Look furnace
6	Material Sent For Hardening On Date			23	3	24			

### Inspected By (Sign) & Date

Ravi 23/3/24

Reviewed by (Engineer-CNC)  
23/3/24

Manager-QA