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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.		11868	40/50
2	Machined By		V.T.L. N/C Shop	Dy. No. (2.01) 286
3	Pallet Die No.		11649 (4.0) - 44	Rev. No.
4	Die Category	Drg. No.	53370	
5	Out Side Diameter	Drg. No.	620mm Step OD 620mm	Tapken 12
6	Inside Diameter	Drg. No.	520.12mm	Step length 18mm
7	Width of Pellet Die	Drg. No.	186mm	Under cut 2mm
8	Grooves as per Drawing	Drg. No.	13x8x3mm   13x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping Holes of Holes 12
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M2, Check by M2 Bolt	Bolt Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8mm	Tapping Depth 8-8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 6/5/24

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	4.5mm	Outside (3-3)		Inner		
3	External Relief Depth		14mm		10mm		
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	5	24		

### Inspected By (Sign) & Date

Ravi 6/5/24

Satyam 6/5/24

Reviewed by (Engineer-CNC)

Manager-QA