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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.		11996	4.9/55
2	Machined By		V.T.L. H/c Shop	Drg. No. 1.302355
3	Pallet Die No.		12157 (4.0) H/c	Rec. Co.
4	Die Category	Drg. No.	58810	
5	Out Side Diameter	Drg. No.	630 H/c	Step CO = 612 H/c, Step length 10 mm
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/c   13x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes = 12 Back Side
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		H/c = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 H/c	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 17/5/24

As per programme no.		
Gun Drilling Work Completed On		
Hole Finish In Gun Drilling	Marked	ok
Defective Holes (If Any)		No

te : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 60°

Counter Sinking Depth & Finish	ok									Low = 25
External Relief Dia	4.5 H/c	outside (3-3)		Inner						
External Relief Depth		17 H/c		13 H/c						
Inspection Done Before Hardening By (Name)										Ravi
Material Sent For Hardening By (Name)										Lark Furnace
Material Sent For Hardening On Date			17	5	24					

**Inspected By (Sign) & Date**

Ravi 17/5/24

Satguru  
17/5/24  
d by (Engineer-CNC)

Manager-QA