

7505



# 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.			
2	Machined By		INV	42/50
3	Pallet Die No.		V.T.L. n/c Shop	Drg. No. L20293
4	Die Category	Dr. No.	12166(400) n/c	Rev. 00
5	Out Side Diameter	Dr. No.	Endside	
6	Inside Diameter	Dr. No.	62mm, 3rd step OD = Tapper = 12° Step length = 18	
7	Width of Pellet Die	Dr. No.	520.12 mm	
8	Grooves as per Drawing	Dr. No.	222 mm	
9	Fitting Sizes on CNC Plate	Dr. No.	13x8x5 mm / 13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		H2 = Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.8 mm Tapping Depth = 13.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ravi 16/5/24

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.3 mm	Outside (3-3)		Inner					
3	External Relief Depth		16 mm		8 mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date			16	5	24				

**Inspected By (Sign) & Date**

Ravi 16/5/24

Satya 16/5/24

Reviewed by (Engineer-CNC)

Manager-QA