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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.		12004	29/50
2	Machined By		V. T. L. n/c Shop	Drg No. 1.20
3	Pallet Die No.		9982 (2.8) n/c	Pen 201
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 n/c	Step 002 692.8 n/c
6	Inside Diameter	Drg. No.	600.12 n/c	Tabber - 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length 20 n/c
8	Grooves as per Drawing	Drg. No.	12+8 x 7 n/c / 12+8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/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

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 260
2	External Relief Dia	3.3 n/c	outside (3-3)		Inner				Cap = 41
3	External Relief Depth		23 n/c		21 n/c				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	5	24				

Inspected By (Sign) & Date

Ravi 17/5/24

Reviewed by (Engineer-CNC)

Manager-QA