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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.		19302	48/55
2	Machined By		V.T.L M/C SHOP	Drg No - LSD 526
3	Pallet Die No.		19668 (4.0mm)	(REV00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	740mm	Step length - 27.5mm
6	Inside Diameter	Drg. No.	630.12mm	Taper - 4°
7	Width of Pellet Die	Drg. No.	255mm	Under cut - 1.5mm
8	Grooves as per Drawing	Drg. No.	22X8X7mm / 22X8X7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 12 Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M 22 check by M 22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 28.4mm Tapping Depth - 26.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 04/07/24

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								Row - 34
2	External Relief Dia	4.5mm	outside (3.3)	inner						
3	External Relief Depth		15mm	7mm						
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		04	07	24					

### Inspected By (Sign) & Date

Ramanpreet Singh 04/07/24

Reviewed by (Engineer-CNC)

Manager-QA