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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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12322	33/50 ✓
2	Machined By		V.T.L M/C Shop	Drg No - LSP 450
3	Pallet Die No.		11881 (3.0mm)	CRev00 ✓
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm Step of - 743.4mm	Step length - 23mm ✓
6	Inside Diameter	Drg. No.	630.14mm	Under cut - 6.75mm ✓
7	Width of Pellet Die	Drg. No.	290mm	Taper - 10° ✓
8	Grooves as per Drawing	Drg. No.	15X8X5mm / 15X8X5mm	✓
9	Fitting Sizes on CNC Plate	Drg. No.	✓ ok ✓	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 16 Both Side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		685mm ✓	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	✓ ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	✓
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 02/07/24

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 - 52
2	External Relief Dia	3.5mm	outside (3.3)	Inner					
3	External Relief Depth	✓	23mm	17mm					
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		02	07	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 02/07/24

Manager-QA

Reviewed by (Engineer-CNC)