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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.			
2	Machined By		INV to 12371	35/50
3	Pallet Die No.		V.T.L M/C Shop	Part No - LEC 9980
4	Die Category	Drg. No.	12586 (3.5mm)	(REV 00)
5	Out Side Diameter	Drg. No.	SSEW	
6	Inside Diameter	Drg. No.	620mm	Step of Tapper - 12°
7	Width of Pellet Die	Drg. No.	520.14mm	Step length - 18.5mm
8	Grooves as per Drawing	Drg. No.	222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13X8X5mm / 13X8X5mm	
10	Drilling Area Surface Smoothness		OK	[ Tapping No. of Holes 12 Both Side ]
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		565mm	
14	Tapping On Second Side	Half pitch of 1st side	M20 check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	

### Inspected By (Sign) & Date

Ramanjeet Singh 29/06/24

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 - 60°
2	External Relief Dia	3.8mm	outside (3-3)	Inner				Row - 35
3	External Relief Depth	-	19mm	15mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		29	06	24			

### Inspected By (Sign) & Date

Ramanjeet Singh 29/06/24

29/6/24

Reviewed by (Engineer-CNC)

Manager-QA