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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.		19760	41/50
2	Machined By		VTL M/c Shop	Proj No - LSD 1100
3	Pallet Die No.		19747 (3.0mm)	CRV00
4	Die Category	Dr. No.	Jumbo	
5	Out Side Diameter	Dr. No.	730.44	Step 00, 743mm
6	Inside Diameter	Dr. No.	630.12	Step length - 97.5mm
7	Width of Pellet Die	Dr. No.	97.5mm	Tapper, 4°
8	Grooves as per Drawing	Dr. No.	PPX 8X 7mm / PPX 8X 7mm	Under cut, 6.5mm
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 12 Both Side ]
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 08/08/24

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 1 Hole close (A)

**Note :** Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°

1	Counter Sinking Depth & Finish	ok							Row - 46
2	External Relief Dia	3.3mm	outside (3-3)	Inner					
3	External Relief Depth		13mm	9mm					
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		08	08	24				

**Inspected By (Sign) & Date**

Ramanpreet Singh 08/08/24

Reviewed by (Engineer-CNC)

Manager-QA