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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.		19424 ✓	39/50 ✓
2	Machined By		VTL M/c Shop	Drg No - LSD 939
3	Pallet Die No.		19955 (98mm) ✓	(REV 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	760 H.H. ✓	Step length - 26mm
6	Inside Diameter	Drg. No.	660.12 H.H. ✓	Tapber 29.5°
7	Width of Pellet Die	Drg. No.	316mm ✓	Under cut 20.5mm
8	Grooves as per Drawing	Drg. No.	18x9x6mm / 18x9x6mm	
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		725mm ✓	
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 - 20.5mm	
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 5 Hole close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 600

1	Counter Sinking Depth & Finish	OK							Row-59
2	External Relief Dia	3.3mm	outside (3-3)	Inner					
3	External Relief Depth		25mm	18mm					
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

*Satya*  
08/08/24

Reviewed by (Engineer-CNC)

Manager-QA