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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.		12610	30/38/60
2	Machined By		V.T.L M/C Shop	Des No- LSD 727
3	Pallet Die No.		12758 (40mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm	Step depth- 26.5mm
6	Inside Diameter	Drg. No.	680.12 mm	Under cut- 26mm
7	Width of Pellet Die	Drg. No.	324mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8mm / 21.5 x 8 x 8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No. of ]
10	Drilling Area Surface Smoothness		ok	Holes 12
11	Tapping Operator		M/C Shop	Both Side
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- 31.4mm - Tapping depth- 29.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 21/08/24

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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter 30

1	Counter Sinking Depth & Finish	ok						Row-47
2	External Relief Dia	4.8mm, 5.0mm	4.8mm		5.0mm	All Rows		
3	External Relief Depth		30mm		22mm			
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		21	08	24			

Inspected By (Sign) & Date Ramanpreet Singh 21/08/24

Reviewed by (Engineer-CNC) [Signature] 21/8/24

Manager-QA