

8.25



# 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.		12660	37/70
2	Machined By		V.T.C M/c Shop	Drg No - LEC 12/09
3	Pallet Die No.		13343 (3.0mm)	(Rev 02)
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1287 mm	Step length - 28mm
6	Inside Diameter	Drg. No.	1145.12 mm / 1145.4 mm	
7	Width of Pellet Die	Drg. No.	388.5 mm	
8	Grooves as per Drawing	Drg. No.	26 X 6 X 18 mm / 26 X 6 X 18 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 20 ]
11	Tapping Operator		M/c Shop	[ Both Side ]
12	Tapping PCD		1210 mm	
13	Tapping Hole Diameter		M 24 Check by M 24 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 33.4 mm Tapping Depth - 31.8 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 17/09/24

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 2 Hole close

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter-60° Row-69

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.8 mm	outside 24-45	Inner			
3	External Relief Depth		37 mm	31 mm			
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		17	09	24		

Inspected By (Sign) & Date Ramanpreet Singh 17/09/24

Satya 17/09/24

Reviewed by (Engineer-CNC)

Manager-QA