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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.		13375 ✓	33/40 ✓
2	Machined By		V.T.L M/c Shop	Part No - LEC 15067
3	Pallet Die No.		17698 (3.0mm)	(REV 01)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm Step up - 491mm	Step Length - 18mm
6	Inside Diameter	Drg. No.	490.12mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	1P x 8 x 3mm / 1P x 8 x 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 1P Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm ✓	
13	Tapping Hole Diameter		12" M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth - 18.4mm Tapping depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 23/11/24

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						
2	External Relief Dia	3.5mm	outside (P-P)	Inner			
3	External Relief Depth		13mm	7mm			
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	23	11	24			
Inspected By (Sign) & Date		Ramanpreet Singh 23/11/24					

Reviewed by (Engineer-CNC) Sats 23/11/24

Manager-QA