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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.		11881	45/60
2	Machined By		V.T.L MIC Shop	Drg No LSD-584
3	Pallet Die No.		12300 (8.0mm)	(Keyol)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Stel od-798mm	Tapper - 4°
6	Inside Diameter	Drg. No.	660.12mm	Stel length 25.5
7	Width of Pellet Die	Drg. No.	324mm	Under cut 9.0mm
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10mm / 21.5 x 8 x 10mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok	Holes 12 Both
11	Tapping Operator		MIC Shop	Side
12	Tapping PCD		725mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31mm Tapping Depth - 28.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date		Ramanjeet Singh 21/5/24		[ 2 Slot ]	
1	As per programme no.		—	32.1mm width	
2	Gun Drilling Work Completed On		—	8mm deep	
3	Hole Finish In Gun Drilling	Marked	ok	Both Side	
4	Defective Holes (If Any)		No		

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

1	Counter Sinking Depth & Finish	ok						Counter - 60° Row - 27
2	External Relief Dia	8.5mm	outside (3-3)	Inner				
3	External Relief Depth		23mm	15mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		21	5	24			

Inspected By (Sign) & Date Ramanjeet Singh 21/5/24

Satyam 21/5/24

viewed by (Engineer-CNC)

Manager-QA