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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.		11905	33/46
2	Machined By		V.T.L M/C SHOP	Drg No - LSD-1041
3	Pallet Die No.		11746 (3.0mm)	(REV 0)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4/0 Step of - 384mm	step length - 16.5mm
6	Inside Diameter	Drg. No.	315.12 / 318.12 mm	
7	Width of Pellet Die	Drg. No.	134mm	Maintain after Hard machining
8	Grooves as per Drawing	Drg. No.	4x5x3mm / 4x5x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C SHOP	Both Side
12	Tapping PCD		350mm	
13	Tapping Hole Diameter		1/2" Check by 1/2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 17mm Tapping Depth - 14.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 28/5/24

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 - 60°

1	Counter Sinking Depth & Finish	ok								Row-22
2	External Relief Dia	3.5mm	outside (2-2)	Inner						
3	External Relief Depth		19mm	13mm						
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		28	5	24					

### Inspected By (Sign) & Date

Ramanpreet Singh 28/5/24

*[Signature]*  
28/5/24

Reviewed by (Engineer-CNC)

Manager-QA