

7625



# 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.		12097	21/40
2	Machined By		V.T.L M/C Shop	Drg No - LSD 21
3	Pallet Die No.		11838 (ø 8mm)	C Rev oil
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm Step ø D - 499 mm	Step Length - 17 mm
6	Inside Diameter	Drg. No.	420.12 mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12X8X3mm / 12X8X3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		3/4 Check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.8 mm Tapping Depth - 16.7 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 06/6/24

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 - 26
2	External Relief Dia	3.3 mm	outside (ø 2)	Inner					
3	External Relief Depth		22 mm	19 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		06	6	24				

Inspected By (Sign) & Date Ramanpreet Singh 06/6/24

Satya  
6/6/24

Reviewed by (Engineer-CNC)

Manager-QA