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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.		12041	30/45
2	Machined By		V.T.L M/C Shop	Drg No - LSP 1060
3	Pallet Die No.		11748 (40mm)	(REV 00)
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.5mm	Step length - 9.5mm
6	Inside Diameter	Drg. No.	315.12mm	
7	Width of Pellet Die	Drg. No.	145mm	
8	Grooves as per Drawing	Drg. No.	8x8x3mm / 8x8x3mm	
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		360mm / 355mm	
13	Tapping Hole Diameter		M12 <del>3/4</del> check by <del>M12</del> 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.6mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet Singh 13/06/24

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 - 18
2	External Relief Dia	4.5mm	outside (2-2)	Inner						
3	External Relief Depth		19mm	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		13	06	24					

Inspected By (Sign) & Date Ramanjeet Singh 13/06/24

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Reviewed by (Engineer-CNC) 13/6/24

Manager-QA