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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.		19050	33/66
2	Machined By		V.T.L M/C Shop	Drg No - LSD-609
3	Pallet Die No.		19489 (6.0mm)	(REV)
4	Die Category	Drg. No.	M. Jumbo groove 413mm	
5	Out Side Diameter	Drg. No.	680.7mm - step od - 693mm	step length - 31mm / 33mm
6	Inside Diameter	Drg. No.	548.14mm (B)	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x7.6mm (B)	4x7.6mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 4 ]
10	Drilling Area Surface Smoothness		OK	[ Both Side ]
11	Tapping Operator		M/C Shop	Face step
12	Tapping PCD		619mm	2mm Deep Both Side
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 35mm Tapping Depth - 32mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet 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 - 30°

1	Counter Sinking Depth & Finish	OK						Row - 19
2	External Relief Dia	7.5mm						
3	External Relief Depth	33mm	All Rows					
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		13	06	24			

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

S.S.  
13/6/24

Reviewed by (Engineer-CNC)

Manager-QA