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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.		12116	33/48/70	
2	Machined By		V.T.L M/C Shop	Drg No - LSP 377	
3	Pallet Die No.		12762 (6.0mm)	(REV 03)	
4	Die Category	Drg. No.	M. Jumbo		
5	Out Side Diameter	Drg. No.	688mm	Step Length - 33.5mm	
6	Inside Diameter	Drg. No.	548.12mm	Taper - 5°	
7	Width of Pellet Die	Drg. No.	215mm	Under cut - 1.75mm	
8	Grooves as per Drawing	Drg. No.	29.5 X 10 X 8mm / 29.5 X 10 X 8mm	6 X 8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 2 Both Side ]	
10	Drilling Area Surface Smoothness		OK		
11	Tapping Operator		M/C Shop		
12	Tapping PCD		618mm	Face side Step	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	1mm Deep Both Side	
14	Tapping On Second Side	Half pitch of 1st side	OK		
15	Tapping Hole Depth		Drill Depth - 33.5mm Tapping Depth - 30.5mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ramanpreet Singh 17/06/24		
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					
1	Counter Sinking Depth & Finish	OK		Row - 14	
2	External Relief Dia	6.5mm, 7.3mm	6.5mm	7.3mm	
3	External Relief Depth		37mm	22mm	
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		17	06	24
Inspected By (Sign) & Date			Ramanpreet Singh 17/06/24		

*Satyan*  
17/06/24

Reviewed by (Engineer-CNC)

Manager-QA