

# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12169	45/50
2	Machined By		V.T.L M/C Shop	Drg No - Lark Std
3	Pallet Die No.		12590 (2.5mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	619.9mm	Step of - 611.9mm
6	Inside Diameter	Drg. No.	520.12mm	Step Length - 19.5mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 27/06/24

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 2 Hole close

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter - 60  
Row - 43

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	2.8mm	outside (3-3)	Inner		
3	External Relief Depth		10mm	5mm		
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		27	06	24	

Inspected By (Sign) & Date

Ramanjeet Singh 27/06/24

Reviewed by (Engineer-CNC)

Manager-QA