



# 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.		12231	42/50
2	Machined By		V.T.L M/C Shop	Drg No - LSD 322
3	Pallet Die No.		12324 (4.0mm)	(Revoo)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm Step od - 500mm	Step Length - 18mm
6	Inside Diameter	Drg. No.	420 12mm	Taper - 10°
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
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		455mm	
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 - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanjeet Singh 24/06/24	
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 Row - 20				
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	4.5mm	outside (r-r) Inner	
3	External Relief Depth		12mm 8mm	
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		24 06 24	
Inspected By (Sign) & Date			Ramanjeet Singh 24/06/24	

Satish 24/06/24

Reviewed by (Engineer-CNC)

Manager-QA