



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7739

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.			
2	Machined By		12168	34.5 / 54.5
3	Pallet Die No.		V.T.L M/C Shop	Drg No - LSD 731
4	Die Category	Drg. No.	12763 (4.0mm)	(Rev 00)
5	Out Side Diameter	Drg. No.	SELW	
6	Inside Diameter	Drg. No.	529mm	Step length - 20mm / 9.5mm
7	Width of Pellet Die	Drg. No.	420.12mm	Under Cwt - 1.5mm
8	Grooves as per Drawing	Drg. No.	190mm	
9	Fitting Sizes on CNC Plate	Drg. No.	42 X 6 X 2mm / 18 X 6 X 7mm	
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 8 ]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		480mm	
14	Tapping On Second Side	Half pitch of 1st side	M16 Check by M16 Bolt	
15	Tapping Hole Depth		1 Side Tapping 2nd side / Slot	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

### Inspected By (Sign) & Date

Ramanjeet Singh 27/06/24

1 Slot 28mm

1	As per programme no.			Width 10.5mm
2	Gun Drilling Work Completed On			Deep
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 (2-3)	Inner			
3	External Relief Depth		24mm	20mm			
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

Satyam 27/6/24

Reviewed by (Engineer-CNC)

Manager-QA