



# 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.		12323 ✓	40/50 ✓
2	Machined By		Y.T.L M/C Shop	Drg No- LSD 406
3	Pallet Die No.		12605 (5.0mm) ✓	(REV 00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm ✓	Step length- 18mm
6	Inside Diameter	Drg. No.	520.12mm ✓	Tapper- 12°
7	Width of Pellet Die	Drg. No.	222mm ✓	Underwt- 1.2mm ✓
8	Grooves as per Drawing	Drg. No.	13X8X5 mm / 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		M20 Check by M20 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 10/07/24

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 - 26

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.5mm	outside (3-3)	Inner			
3	External Relief Depth		15mm	10mm			
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		10	07	24		

Inspected By (Sign) & Date Ramanjeet Singh 10/07/24

Reviewed by (Engineer-CNC) Satya 10/07/24

Manager-QA