



# 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.		1R177	45/50
2	Machined By		V.T.L M/c shop	Part No-LSP 1072
3	Pallet Die No.		12918 (4.0mm)	(REV 00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	5 $\phi$ 20 mm	Step of- 49/2mm
6	Inside Diameter	Drg. No.	4 $\phi$ 20.12mm	Step length- 16.5mm
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	10 X 8.5 X 5 mm / 10 X 8.5 X 5 mm	
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		45.5mm	
13	Tapping Hole Diameter		3/4 check by 3/4 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

Ramanpreet Singh 15/07/24

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°

1	Counter Sinking Depth & Finish	OK								Row- 24
2	External Relief Dia	4.5mm	outside (3-3)	Inner						
3	External Relief Depth	/	13mm	5mm						
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		15	07	24					

### Inspected By (Sign) & Date

Ramanpreet Singh. 15/07/24

Satya 16/7/24

Reviewed by (Engineer-CNC)

Manager-QA