



# 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.		12418	36/45/50
2	Machined By		V.T.L M/C Shop	Drg No-LSP 259
3	Pallet Die No.		12631 (4.0mm)	CRV02
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm Step 00.622.3	Step Length - 18mm
6	Inside Diameter	Drg. No.	520.12mm	Tappet 12
7	Width of Pellet Die	Drg. No.	229mm	Under cut - 1.2mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm   12.4x8x5mm	
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 20/07/24

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-31
2	External Relief Dia	4.5mm, 5.0mm	4.5mm	5.0mm			
3	External Relief Depth		1.4mm	5mm	All Rows		
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		20	07	24		

Inspected By (Sign) & Date Ramanjeet Singh 20/07/24

Reviewed by (Engineer-CNC) Satya 22/7/24

Manager-QA