



# 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.		1P5P	45/50
2	Machined By		VTL Mic Shop	Drg No - LSD 473
3	Pallet Die No.		1P54P (50mm)	(Rev 00)
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	700mm	Step Length - 90mm
6	Inside Diameter	Dr. No.	600.19mm	Taper - 10°
7	Width of Pellet Die	Dr. No.	222mm	
8	Grooves as per Drawing	Dr. No.	12X 10 X 7.5mm / 12X 10 X 7.5mm	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	[ Tapping No. of Holes R Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		640mm	
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 - 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 05/08/24

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 - P6
2	External Relief Dia	5.5mm	outside (3-3)	Innee						
3	External Relief Depth		10mm	5mm						
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		05	08	24					

### Inspected By (Sign) & Date

Ramanjeet Singh 05/08/24

Reviewed by (Engineer-CNC)

Manager-QA