

# 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.		12607	34/60
2	Machined By		VTL M/c Shop	Drg No- LSD III
3	Pallet Die No.		12757 (40mm)	(Revoo)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm	Step Length- 26.5mm
6	Inside Diameter	Drg. No.	660.12mm	Under Cut- 6mm
7	Width of Pellet Die	Drg. No.	324mm	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8mm / 21.5 x 8 x 8mm	
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		725mm	
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- 31.4mm Tapping Depth- 27.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanjeet Singh 09/08/24

2 Slot 32mm

1	As per programme no.		—	Width 8mm
2	Gun Drilling Work Completed On		—	Deep Both Side
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- 46
2	External Relief Dia	7.8mm	outside (3-3)	Inner					
3	External Relief Depth		30mm	26mm					
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		09	08	24				

### Inspected By (Sign) & Date

Ramanjeet Singh 09/08/24

Satyam 9/8/24

Reviewed by (Engineer-CNC)

Manager-QA