



# 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.		12537	40/50
2	Machined By		V.T.L M/C Shop	Drg No- LSD 778
3	Pallet Die No.		12311 (6.0mm)	(REV00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm	Step length-14.5mm
6	Inside Diameter	Drg. No.	Step of 492mm	
7	Width of Pellet Die	Drg. No.	420.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 8 Both Side ]
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	3/4 check by 3/4 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth- 18.4mm Tapping Depth- 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 13/08/24

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							
2	External Relief Dia	6.5mm	outside (2-3)	Inner					
3	External Relief Depth		16mm	10mm					
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		13	08	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 13/08/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA