



# 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.		INV	33/50
2	Machined By		V.T.L M/c Shop	Drg No-Lark Std
3	Pallet Die No.		1P6PP (3.0mm)	1355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	6 $\phi$ 0mm	Step length-19.5mm
6	Inside Diameter	Drg. No.	5 $\phi$ 0-12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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		M $\phi$ 0 check by M $\phi$ 0 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 27/07/24

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-38
2	External Relief Dia	3.3mm	outside (3-3)	Inner					
3	External Relief Depth		23mm	17mm					
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		27	07	24				

### Inspected By (Sign) & Date

Ramanjeet Singh 27/07/24

27/7/24

Reviewed by (Engineer-CNC)

Manager-QA