



# 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.			
2	Machined By		12641	32/40
3	Pallet Die No.		V.T.L M/C Shop	Des No-LSD 952
4	Die Category	Dr. No.	12351 (4.0mm)	(Rev00)
5	Out Side Diameter	Dr. No.	Senior	
6	Inside Diameter	Dr. No.	500 HD Step OD - 493	Step Length - 17.5mm
7	Width of Pellet Die	Dr. No.	420.12 HD	
8	Grooves as per Drawing	Dr. No.	160mm	
9	Fitting Sizes on CNC Plate	Dr. No.	11x5x3mm / 11x5x3mm	
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 - 16.6mm	
17	Visual Inspection Before Gun Drilling		Yes	

### Inspected By (Sign) & Date

Ramanjeet Singh 24/08/24

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  
Row - 22

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (P-2)	Inner			
3	External Relief Depth		12mm	8mm			
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		24	08	24		

### Inspected By (Sign) & Date

Ramanjeet Singh 24/08/24

Signature  
24/08/24

Reviewed by (Engineer-CNC)

Manager-QA