



# 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.		12698 ✓	40/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		12683 (4.0mm)	9/09 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400mm	Step of - 395mm
6	Inside Diameter	Drg. No.	320.12mm	Step Length - 14.5mm ✓
7	Width of Pellet Die	Drg. No.	142mm	
8	Grooves as per Drawing	Drg. No.	15.5 X 7 X 2mm	15.5 X 7 X 2mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8 Both Side ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		355mm	✓
13	Tapping Hole Diameter		M16 check by M16 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

Ramanpreet 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°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3mm	outside 0.2	Inner					Round
3	External Relief Depth	✓	4mm	0					
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		24	08	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

Saksu 24/8/24

Reviewed by (Engineer-CNC)

Manager-QA