

# 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.		12510 ✓	60/60 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 1050
3	Pallet Die No.		13029 (3.0mm) ✓	(REV00) ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	750H ✓	Step length - 23mm
6	Inside Diameter	Drg. No.	630.12 H ✓	Tapper = 10°
7	Width of Pellet Die	Drg. No.	265mm ✓	
8	Grooves as per Drawing	Drg. No.	15x8x5mm / 15x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 16
11	Tapping Operator		M/c Shop	
12	Tapping PCD		685mm ✓	Both Side ✓
13	Tapping Hole Diameter		M20 check by M20 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 27/08/24

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 - 6°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	No Relief							
3	External Relief Depth								
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		27	08	24				

Inspected By (Sign) & Date

Ramanpreet Singh 27/08/24

Reviewed by (Engineer-CNC)

Manager-QA