

# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		12668	36/45/55
2	Machined By		V.T.C M/c Shop	Drg No- LSD 470
3	Pallet Die No.		12881 (4.0mm)	(Key 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710mm	Step Length-19.5mm
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12.5x8x7mm / 12.5x8x7mm	
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		645mm	
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-22.4mm Tapping Depth-20.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 29/08/24

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-32

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	4.5mm, 5.0mm	4.5mm	5.0mm	All Rows	
3	External Relief Depth		19mm	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		29	08	24	

### Inspected By (Sign) & Date

Ramanpreet Singh 29/08/24

S. J. S. 29/8/24

Reviewed by (Engineer-CNC)

Manager-QA