

# 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.		19682 ✓	35/40 ✓
2	Machined By		V.T.L M/C Shop	Drp No - IEC 15069
3	Pallet Die No.		11827 (3.2mm)	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 HZ Step 0.2 = 498.8	Step length - 18mm
6	Inside Diameter	Drg. No.	420.14 HZ (B)	Tapper = 12 ✓
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
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		454mm ✓	
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 - 18.4mm Tapping depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ramanjeet Singh 24/08/24

1	As per programme no.		—	Completed from Taper to St. After Hardening.
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 - 23

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	outside (2-2)	Inner			
3	External Relief Depth		11mm	5mm			
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*  
24/8/24  
Reviewed by (Engineer-CNC)

Manager-QA