

# 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.		12739 ✓	34/44/55 ✓
2	Machined By		V.T.L M/c Shop	Drg No- LSP 407 ✓
3	Pallet Die No.		12207 (4.0mm) ✓	(REV00) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710mm ✓	Step length- 20mm ✓
6	Inside Diameter	Drg. No.	600.12mm ✓	Taper- 12° ✓
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	12X8X7mm / 12X8X7mm	
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		640mm ✓	
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

Ramanjeet 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°

1	Counter Sinking Depth & Finish	ok						Row- 32
2	External Relief Dia	4.5mm, 5.0mm	4.5mm	5.0mm	All Rows			
3	External Relief Depth	✓	21mm	11mm				
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		29	08	24			

### Inspected By (Sign) & Date

Ramanjeet Singh 29/08/24

Reviewed by (Engineer-CNC)

Manager-QA