

# 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.		12720	28/50
2	Machined By		V.T.L M/c Shop	Drg No - LEC 11286
3	Pallet Die No.		11859 (2.8mm)	(REV 02)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620mm Step of - 623.9mm	Step Length - 18mm
6	Inside Diameter	Drg. No.	520.12mm	Taper - 1°
7	Width of Pellet Die	Drg. No.	186mm	Under Cut - 1.9mm
8	Grooves as per Drawing	Drg. No.	13x8x3mm / 13x8x3mm	
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		565mm	
13	Tapping Hole Diameter		M 20 check by M 20 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 30/08/24

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 3F
2	External Relief Dia	3.3mm	outside	Inner						
3	External Relief Depth		25mm	22mm						
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		30	08	24					

### Inspected By (Sign) & Date

Ramanpreet Singh 30/08/24

Saty 30/08/24

Reviewed by (Engineer-CNC)

Manager-QA