

# 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.		19838	42/50
2	Machined By		VTL M/c Shop	Drg No - L2R Std
3	Pallet Die No.		19174 (30mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm ✓	Step od - 612mm ✓
6	Inside Diameter	Drg. No.	520.12mm ✓	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok ✓	[ Tapping No. of Holes 18 Both Side ]
10	Drilling Area Surface Smoothness		ok ✓	
11	Tapping Operator		M/c Shop ✓	
12	Tapping PCD		565mm ✓	
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 07/09/24	
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	
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	ok		Counter 62 Row - 38
2	External Relief Dia	3.5mm	outside (3-3) Inner	
3	External Relief Depth		14mm 8mm ✓	
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		07 09 24	
Inspected By (Sign) & Date			Ramanpreet Singh 07/09/24	

Reviewed by (Engineer-CNC)

Manager-QA