

# 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.		12751	45/56
2	Machined By		V.T.L M/c Shop	Drwg No- LSD/1138
3	Pallet Die No.		12675 (8.0mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 H-H Step 00, 612 H-H	Step length-19.5mm
6	Inside Diameter	Drg. No.	518.12mm	one side 10 Step = 520.12mm
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	14x6x3 H-H / 14x6x3 H-H	
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		565mm	
13	Tapping Hole Diameter		5/8" check by 5/8" 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 05/09/24	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker <span style="float: right;">Counter-60°</span>				
1	Counter Sinking Depth & Finish	OK		Row-14
2	External Relief Dia	8.5mm	outside 3.3 Inner	
3	External Relief Depth		15mm 11mm	
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		05 09 24	
Inspected By (Sign) & Date			Ramanpreet Singh 05/09/24	

Reviewed by (Engineer-CNC)

Manager-QA