



# 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

Rev. Date

31-07-2013

## Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12776	50/55
2	Machined By		V.T.L M/c Shop	Drg No - USD 869
3	Pallet Die No.		13984 (8.0mm)	(Rev00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	530 mm	Step od - 491mm
6	Inside Diameter	Drg. No.	420-12mm	Step Length - 17.5mm
7	Width of Pellet Die	Drg. No.	182mm	
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	
10	Drilling Area Surface Smoothness		ok	[ Tapping No. of Holes 8 ]
11	Tapping Operator		M/c Shop	[ Both Side ]
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

Ramanpreet Singh 06/09/24

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

Counter-60°

Row-15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5mm	outside (7-7)	Inner			
3	External Relief Depth		13mm	5mm			
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		06	09	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 06/09/24

Signature 06/09/24

Reviewed by (Engineer-CNC)

Manager-QA