

# 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.		12774 ✓	38/40 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 400
3	Pallet Die No.		12367 (4.0mm)	(CRV00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm, Step od-49mm	Step length-13.5mm ✓
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	159mm ✓	
8	Grooves as per Drawing	Drg. No.	7x7x5mm / 7x7x5mm ✓	
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		455mm ✓	
13	Tapping Hole Diameter		3/4 Check by 3/4 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth-22.4mm Tapping Depth-20.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet 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	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter-60°

1	Counter Sinking Depth & Finish	ok							Row-21
2	External Relief Dia	4.5mm	outside	Inner					
3	External Relief Depth		6mm	2mm					
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		07	09	24				

Inspected By (Sign) & Date

Ramanjeet Singh 07/09/24

Reviewed by (Engineer-CNC)

Manager-QA