



# 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.		12867 ✓	45 / 50 ✓
2	Machined By		V.T.L M/c Shop	Dwg No - LSD 71
3	Pallet Die No.		13092 (8.0mm)	(REV 00)
4	Die Category	Drg. No.	SSEW ✓	✓
5	Out Side Diameter	Drg. No.	620mm ✓	Step OD - 623.1mm
6	Inside Diameter	Drg. No.	520.12mm ✓	Step Length - 17mm
7	Width of Pellet Die	Drg. No.	222mm ✓	Taper - R°
8	Grooves as per Drawing	Drg. No.	9.0 x 10 x 4mm / 9.0 x 10 x 4mm	Under cut - 1.6mm ✓
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 25/09/24

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 - 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5mm	outside (3-3)	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		25	09	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 25/09/24

25/9/24

Reviewed by (Engineer-CNC)

Manager-QA