



# 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)

8594

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		B.P.P.	30/42
3	Pallet Die No.		V.T.L Mic Shop	Drwg No-2SD/178
4	Die Category	Dr. No.	13546 (4.0mm)	(R.Voc)
5	Out Side Diameter	Dr. No.	Jurnal	
6	Inside Diameter	Dr. No.	355 mm, OD 874-388	Step length-9.3
7	Width of Pellet Die	Dr. No.	315 mm	
8	Grooves as per Drawing	Dr. No.	145 mm	
9	Fitting Sizes on CNC Plate	Dr. No.	8x3x3 mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 8 Both Side
11	Tapping Operator		Mic Shop	
12	Tapping PCD		M12, 360, 355 mm	
13	Tapping Hole Diameter		M12, 0.314" check by M12, 0.314" Reel	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-20.3, Tapping Depth-18.5 mm 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 16/11/24

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				
2	External Relief Dia	4.5mm	outside (P-P)	Inner		
3	External Relief Depth		16mm	12mm		
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		16	11	24	

### Inspected By (Sign) & Date

Ramanpreet Singh 16/11/24

18/11/24

Reviewed by (Engineer-CNC)

Manager-QA