



# 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.		13301 ✓	40/50
2	Machined By		V.T.C M/c Shop	Dr. No - 292KStd
3	Pallet Die No.		13387 (4.0mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm ✓	Step OD - 612mm
6	Inside Diameter	Drg. No.	590.12mm ✓	Step length - 17.5mm
7	Width of Pellet Die	Drg. No.	772mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
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 to check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 70.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet 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	out side (3.3)	Inncr					
3	External Relief Depth		14mm	10mm					
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		16	11	24				

Inspected By (Sign) & Date

Ramanjeet Singh 16/11/24

Satyam 18/11/24

Reviewed by (Engineer-CNC)

Manager-QA