



# 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.		11921	53/55
2	Machined By		V.T.L M/C SHOP	Drg No. LSP-512
3	Pallet Die No.		11886 (3.8mm)	(Roo)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm Step OD-491mm	Step Length-17.5mm
6	Inside Diameter	Drg. No.	490.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
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	Tapping No. of Holes 8 Both side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		3/4" check by 3/4 Bolt <del>Drill Depth-20mm TAPPING DEPTH-17.5mm</del>	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth-20mm Tapping Depth-17.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ramanpreet Singh 28/5/24

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	4.3mm	outside (2-2)	Inner					
3	External Relief Depth		9mm	9mm					
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		28	5	24				

**Inspected By (Sign) & Date**

Ramanpreet Singh 28/5/24

Sats  
28/5/24

Reviewed by (Engineer-CNC)

Manager-QA