



# 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.		1019	33/50
2	Machined By		V.T.L M/C Shop	Drg No - LSP 276
3	Pallet Die No.		10075 (4.3mm)	(Revol)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620mm Step on 624mm	Step length
6	Inside Diameter	Drg. No.	520.12mm	Tapping 10
7	Width of Pellet Die	Drg. No.	126mm	(Diameter)
8	Grooves as per Drawing	Drg. No.	13x8x3mm   13x8x3mm	
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		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.6 Tapping Depth - 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

<b>Inspected By (Sign) &amp; Date</b>		Ramanpreet Singh 29/5/24		
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-24
2	External Relief Dia	4.8mm	outside (3-3)	2mm					
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		29	5	24				
<b>Inspected By (Sign) &amp; Date</b>		Ramanpreet Singh 29/5/24							

Reviewed by (Engineer-CNC)   
 29/5/24

Manager-QA