



# 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.		12034	40/50
2	Machined By		V.T.L M/C Shop	Drg No - LSD-452
3	Pallet Die No.		11051 (4.0mm)	(Key 00)
4	Die Category	Drg. No.	SEW	
5	Out Side Diameter	Drg. No.	520mm	Step length - 16.5mm
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	173mm	
8	Grooves as per Drawing	Drg. No.	10 X 8.5 X 5mm / 10 X 8.5 X 5mm	
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		455mm	
13	Tapping Hole Diameter		3/4 check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.7mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanjeet Singh 30/5/24

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  
Row - 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (2-2)	Inner			
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		30	5	24		

### Inspected By (Sign) & Date

Ramanjeet Singh 30/5/24

Reviewed by (Engineer-CNC)

Manager-QA