



# 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.		18188	25/45/70, 25/50/70
2	Machined By		V.T.L M/C Shop	Drg No- LSP 377
3	Pallet Die No.		12293 (6.0mm)	(REV 03)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688mm Step od- 697.8mm	Step length - 38.5mm
6	Inside Diameter	Drg. No.	548.12mm	Under cut - 1.75mm
7	Width of Pellet Die	Drg. No.	215mm	
8	Grooves as per Drawing	Drg. No.	29.5 X 10 X 8mm / 29.5 X 10 X 8mm	6 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes ? ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Both side
12	Tapping PCD		618mm	Face side Step
13	Tapping Hole Diameter		M16 check by M16 Bolt	1mm Deep
14	Tapping On Second Side	Half pitch of 1st side	OK	Both side
15	Tapping Hole Depth		Drill Depth - 37.5mm Tapping Depth - 30.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 21/06/24

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

Marked

4 Defective Holes (If Any)

No

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 30

1	Counter Sinking Depth & Finish	OK						Row - 14
2	External Relief Dia		1 <sup>st</sup> Step 7.5mm - 25mm		2 <sup>nd</sup> Step 7.3 - 43mm			
3	External Relief Depth		7mm - 45mm Deep		8.0mm - 20mm			
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		21	06	24			

Inspected By (Sign) & Date

Ramanjeet Singh 21/06/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA