



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7714

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.		12307	44/50	
2	Machined By		V.T.L M/C Shop	Drg No-LarkStd	
3	Pallet Die No.		11627 (4.0mm)	6355	
4	Die Category	Drg. No.	SSEW		
5	Out Side Diameter	Drg. No.	620.1mm	Step length-19.5mm	
6	Inside Diameter	Drg. No.	520.14mm		
7	Width of Pellet Die	Drg. No.	222mm		
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm		
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-21.5mm Tapping Depth-18.8mm		
16	Perpendicularity of Tapped Hole		Yes		
17	Visual Inspection Before Gun Drilling		OK		
Inspected By (Sign) & Date			Ramanjeet Singh 22/06/24		
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		
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>					
1	Counter Sinking Depth & Finish	OK		Counter-60° Row-31	
2	External Relief Dia	4.3mm	outside (3-3)	Inner	
3	External Relief Depth		14mm	6mm	
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		22	06	24
Inspected By (Sign) & Date			Ramanjeet Singh 22/06/24		

Satyam 22/06/24

Reviewed by (Engineer-CNC)

Manager-QA