



# 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.		12335 ✓	30/66, 28/66
2	Machined By		V.T.L M/c Shop	Drg No - LSD 609 ✓
3	Pallet Die No.		12481 (6.0mm) ✓	(Rev 01)
4	Die Category	Drg. No.	M. Jumbo 8200VC-4X3mm	
5	Out Side Diameter	Drg. No.	680.7mm ✓	Step length - 3mm ✓
6	Inside Diameter	Drg. No.	548.12mm ✓	Taper - 8° ✓
7	Width of Pellet Die	Drg. No.	195mm ✓	Under cut - 2.5mm ✓
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm ✓	4 X 8mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Both Side
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt ✓	Face side Step 2mm Deep Both
14	Tapping On Second Side	Half pitch of 1st side	ok	Side ✓
15	Tapping Hole Depth		Drill Depth - 35mm Tapping Depth - 32.8mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramankeet Singh 05/07/24

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 - 30°

1	Counter Sinking Depth & Finish	ok						Row - 12
2	External Relief Dia	7.3mm ✓	1st Pad		2nd Pad			
3	External Relief Depth		36mm ✓		38mm ✓			
4	Inspection Done Before Hardening By (Name)		Ramankeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		05	07	24			

Inspected By (Sign) & Date Ramankeet Singh 05/07/24

Reviewed by (Engineer-CNC)

Manager-QA