



# 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.		12535 ✓	40/40 295
2	Machined By		V.T.L M/c Shop	Drg No-Lark Std
3	Pallet Die No.		9556 (40mm) ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H+ / 3rd cp OD = 491 H+	Step length-17.5mm
6	Inside Diameter	Drg. No.	420.12 H+	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
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		454mm	
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 - 18.3 Tapping Depth - 16.5 H+	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 23/07/24

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 - 60

1	Counter Sinking Depth & Finish	OK								Row - 20
2	External Relief Dia	4.5mm	outside (CP-3)	Inner						
3	External Relief Depth		4mm	0						
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		23	07	24					

Inspected By (Sign) & Date Ramanpreet Singh 23/07/24

Reviewed by (Engineer-CNC) Satya 23/07/24

Manager-QA