



# Lark Engineering Company (India) Pvt. Ltd.

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

79/0

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.			
2	Machined By		19466 ✓	45/45 ✓
3	Pallet Die No.		V.T.L M/C Shop	Drig No- LSD 541
4	Die Category	Drig. No.	11792 (8.0mm)	(Revo) ✓
5	Out Side Diameter	Drig. No.	Junior	
6	Inside Diameter	Drig. No.	410 mm Step OD: 395mm	Step Length- 143mm (A)
7	Width of Pellet Die	Drig. No.	320.12 mm	
8	Grooves as per Drawing	Drig. No.	141.8mm (A)	
9	Fitting Sizes on CNC Plate	Drig. No.	15.5 X 7 X 2 mm / 15.5 X 7 X 2 mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 8 Both Side
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		355mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M 16 check by M 16 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.3mm Tapping Depth - 18.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date Ramanpreet Singh 29/07/24

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° Row - 9

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	8.5mm	Outside (P-R)	Inner			
3	External Relief Depth		8mm	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		29	07	24		

Inspected By (Sign) & Date Ramanpreet Singh 29/07/24

Reviewed by (Engineer-CNC)

Manager-QA