



# Lark Engineering Company (India) Pvt. Ltd.

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

7947

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.		12567 ✓	29/40 ✓
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		8928 (3.0mm)	2195 ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	step of - 471mm
6	Inside Diameter	Drg. No.	470.12mm ✓	step length - 17.5mm ✓
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		M70 check by M70 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 06/08/24

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 / Hole close (D)	

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

Counter-60°

1	Counter Sinking Depth & Finish	ok								Row - 24
2	External Relief Dia	3.3mm ✓	outside (7-7)	Inner						
3	External Relief Depth		14mm ✓	11mm ✓						
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		06	08	24					

### Inspected By (Sign) & Date

Ramanpreet Singh 06/08/24

Reviewed by (Engineer-CNC)

Manager-QA