



# 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.		19654	38/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 19501
3	Pallet Die No.		11912 (4.0mm)	(Rev 01)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	700 H.H. ✓ Step OD - 89.8mm	Step Length - 20mm ✓
6	Inside Diameter	Drg. No.	600.12 H.H. / 600.14 H.H. (D)	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
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		640mm	
13	Tapping Hole Diameter		M to check by M to Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5 Tapping Depth - 18.5 H.H.	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

**Inspected By (Sign) & Date**

Ramanpreet Singh 21/08/24

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

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

Counter - 60°

1	Counter Sinking Depth & Finish	OK								Row - 32
2	External Relief Dia	4.5mm	outside (3-3)	Inner						
3	External Relief Depth		16mm	12mm						
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		21	08	24					

**Inspected By (Sign) & Date**

Ramanpreet Singh 21/08/24

*Signature*  
21/08/24

Reviewed by (Engineer-CNC)

Manager-QA