



# 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.		12581 ✓	50/55 ✓
2	Machined By		V.T.L M/c Shop	Dwg No - LSP 930
3	Pallet Die No.		11889 (8.0mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530mm ✓	Step length - 16.5mm ✓
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	160mm ✓	
8	Grooves as per Drawing	Drg. No.	10x8x5mm / 10x8x5mm ✓	
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		3/4" Check by 3/4" 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 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-12
2	External Relief Dia	8.5mm	outside (3-3)	Inner					
3	External Relief Depth	✓	13mm	5mm					
4	Inspection Done Before Hardening By (Name)		<i>Ramanpreet Singh</i>						
5	Material Sent For Hardening By (Name)		<i>Lark Furnace</i>						
6	Material Sent For Hardening On Date		21	08	24				

Inspected By (Sign) & Date *Ramanpreet Singh 21/08/24*

*Satya 21/08/24*  
Reviewed by (Engineer-CNC)

Manager-QA