



# 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.		12592	39/90
2	Machined By		V.T.C M/c Shop	Prj No - Lark Std
3	Pallet Die No.		12334 (35mm)	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400mm	Step length - 145mm
6	Inside Diameter	Drg. No.	Step OD - 375mm	
7	Width of Pellet Die	Drg. No.	320.12mm	
8	Grooves as per Drawing	Drg. No.	142mm	
9	Fitting Sizes on CNC Plate	Drg. 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 ]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		355mm	[ Both side ]
13	Tapping Hole Diameter		M16 check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

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 - 18
2	External Relief Dia	3.8mm	outside (P-2)	Inner					
3	External Relief Depth	✓	12mm	8mm					
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		17	08	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 17/08/24

*Signature*  
17/08/24

Reviewed by (Engineer-CNC)

Manager-QA