

# 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.		19613	PP/40
2	Machined By		V.T.L M/c Shop	Drg No - LSD 74P
3	Pallet Die No.		19819 (P-8mm)	CRV00
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	600.44	Step length - 21.5mm
6	Inside Diameter	Drg. No.	520.12	Taper - 12°
7	Width of Pellet Die	Drg. No.	333mm	End cut - 10.75
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 1P Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		565.44	
13	Tapping Hole Diameter		H202 Check by H2 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 27/08/24

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

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

1	Counter Sinking Depth & Finish	OK					Counter - 60° Row - 39
2	External Relief Dia	3.1mm	<del>3.1mm</del>	All Rows			
3	External Relief Depth		18mm				
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		27	08	24		

Inspected By (Sign) & Date Ramanpreet Singh 27/08/24

Reviewed by (Engineer-CNC)

Manager-QA