

# 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.			
2	Machined By		12686 ✓	P3/33/66 ✓
3	Pallet Die No.		V.T.L M/c Shop	Des No - LSD 609
4	Die Category	Drg. No.	12938 (6.0mm) ✓	(Rev 01) ✓
5	Out Side Diameter	Drg. No.	M. Jumbo 2200VC-413 ✓	
6	Inside Diameter	Drg. No.	680.1mm ✓	Step OD - 693mm
7	Width of Pellet Die	Drg. No.	548.12mm ✓	Step Length - 31mm
8	Grooves as per Drawing	Drg. No.	195mm ✓	Taper - 8°
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8mm / 32 x 7 x 8mm	Under cut - 2.5mm
10	Drilling Area Surface Smoothness		OK	4 x 8mm
11	Tapping Operator		M/c Shop	[ Tapping No. of Holes 4 ]
12	Tapping PCD		619mm ✓	[ Both Side ]
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	Face Side Step 2mm
15	Tapping Hole Depth		Drill Depth - 34.4mm	Tapping Depth - 31.8mm
16	Perpendicularity of Tapped Hole		Yes	Deep Both Side
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

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 30° Row - 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm			
3	External Relief Depth		43mm	33mm			
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