

# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12682	35/40
2	Machined By		V.T.L M/c Shop	Drg No - Lark Std
3	Pallet Die No.		11801 (3.2mm)	2195
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step od - 491mm
6	Inside Diameter	Drg. No.	420.12mm / 420.14 (P)	Step Length - 17.5mm
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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		M20 check by M20 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**

Ramanjeet Singh 26/08/24

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								
2	External Relief Dia	3.5mm	outside (P-P)	Inner						
3	External Relief Depth		11mm	5mm						
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		P6	08	24					

**Inspected By (Sign) & Date**

Ramanjeet Singh 26/08/24

*[Signature]*  
26/08/24

Reviewed by (Engineer-CNC)

Manager-QA