



# 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.		1232 ✓	55/55 ✓
2	Machined By		VTL M/c Shop	Dr No - LSD 407
3	Pallet Die No.		1280 (5.0mm)	(REV00) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	70.5mm (5) Step OD - 69.3mm ✓	Step Length - 20mm ✓
6	Inside Diameter	Drg. No.	60.12mm ✓	Taper - 1° ✓
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 12 Both side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640	
13	Tapping Hole Diameter		M 20 check by M 20 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 02/09/24

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 1 Hole close (2)

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

Counter - 60°

1	Counter Sinking Depth & Finish	OK								Row - 27
2	External Relief Dia	5.5mm ✓	outside (3.3)	Inner						
3	External Relief Depth		5mm ✓	0 ✓						
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		02	09	24					

Inspected By (Sign) & Date Ramanpreet Singh 02/09/24

Sats 31/9/24

Reviewed by (Engineer-CNC)

Manager-QA