



# 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.		12727	40/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 493
3	Pallet Die No.		12546 (40mm)	(Rev00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600-12mm	Taper - 1°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12 X 10 X 7.5mm / 12 X 10 X 7.5mm	
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		640mm	
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 29/08/24

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 1 Hole close (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°  
Pow - 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		14mm	10mm			
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh				
5	Material Sent For Hardening By (Name)		Leak Furnace				
6	Material Sent For Hardening On Date		29	08	24		

Inspected By (Sign) & Date Ramanpreet Singh 29/08/24

*[Signature]*  
29/8/24

Reviewed by (Engineer-CNC)

Manager-QA