



# 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.		19796	37/44/50
2	Machined By		VTL M/c Shop	Dr. No - LSP 473
3	Pallet Die No.		12549 (30mm)	(Rev00)
4	Die Category	Dr. No.	M Jumbo	
5	Out Side Diameter	Dr. No.	700mm	Step OD - 693mm
6	Inside Diameter	Dr. No.	600.12mm	Step Length - 20mm
7	Width of Pellet Die	Dr. No.	222mm	Taper - 1°
8	Grooves as per Drawing	Dr. No.	12x10x7.5mm / 12x10x7.5mm	
9	Fitting Sizes on CNC Plate	Dr. 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 09/09/24

1 As per programme no.

2 Gun Drilling Work Completed On

3 Hole Finish In Gun Drilling

4 Defective Holes (If Any)

Marked

ok

No

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

Counter - 6°

Row -

1 Counter Sinking Depth & Finish

ok

2 External Relief Dia

3.5mm, 4.0mm

3.5mm

4.0mm

All Rows

3 External Relief Depth

11mm

8mm

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

09

09

24

### Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

Sato 9/9/24

Reviewed by (Engineer-CNC)

Manager-QA