



# 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.		19760	32/50
2	Machined By		V.T.L M/c Shop	Dr. No - LSD 25
3	Pallet Die No.		12550 (28mm)	(REV00)
4	Die Category	Dr. No.	M. Jumbo	
5	Out Side Diameter	Dr. No.	700mm	Step length - 19mm
6	Inside Diameter	Dr. No.	600.19mm	
7	Width of Pellet Die	Dr. No.	220mm	
8	Grooves as per Drawing	Dr. No.	9.5 x 10 x 6mm / 9.5 x 6 x 10mm	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	[ Tapping No. of Holes 12 Both Side ]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		645mm	
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 - 22.4mm Tapping Depth - 20.5mm	
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	Marked	OK
4	Defective Holes (If Any)		No / Hole close

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

Counter - 60°  
Row - 40

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	3.3mm	outside (3-3)	Inner		
3	External Relief Depth		23mm	18mm		
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

Satya 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA