



# 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.		12756 ✓	30/45
2	Machined By		VTL M/c shop	Drg No - LSD 483
3	Pallet Die No.		12767 (50mm)	(REV03)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	400mm	Step of 387mm
6	Inside Diameter	Drg. No.	310.12mm	Step length - 10.5mm ✓
7	Width of Pellet Die	Drg. No.	134mm ✓	
8	Grooves as per Drawing	Drg. No.	8X7X3mm / 8X7X3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of]
10	Drilling Area Surface Smoothness		ok	Holes 8
11	Tapping Operator		M/c shop	Both Side
12	Tapping PCD		350mm ✓	
13	Tapping Hole Diameter		1/2" check by 1/2" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 16.4mm Tapping Depth - 14.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 07/09/24

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	

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

Counter - 60

Row - 15

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.5mm	outside (P-T)	Inner			
3	External Relief Depth		20mm	15mm			
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		07	09	24		

Inspected By (Sign) & Date

Ramanpreet Singh 07/09/24

Reviewed by (Engineer-CNC)

Manager-QA