



# 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.		12789 ✓	38/44/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 450
3	Pallet Die No.		12749 (30mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	73mm ✓ Step od - 743.5mm	Step length - 23mm ✓
6	Inside Diameter	Drg. No.	630.12mm ✓	Tapper - 10° ✓
7	Width of Pellet Die	Drg. No.	290mm ✓	Under wt - 6.75mm ✓
8	Grooves as per Drawing	Drg. No.	15 X 8 X 5mm / 15 X 8 X 5mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 16 Both Side ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		685mm ✓	
13	Tapping Hole Diameter		M to check by M to 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

Ramanjeet Singh 12/09/24

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 - 52 ✓

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm, 4.0mm	3.5mm	4.0mm	ALL ROWS		
3	External Relief Depth	✓	14mm ✓	6mm ✓			
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		12	09	24		

### Inspected By (Sign) & Date

Ramanjeet Singh 12/09/24

Reviewed by (Engineer-CNC)

Manager-QA