



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8179

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.		12777 ✓	55/55 ✓
2	Machined By		V.T.L M/c Shop	Dwg No - LEC 14924
3	Pallet Die No.		12650 (50mm) ✓	(REV 00) ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	630 mm Step 0.0 - 612 ✓	Step Length - 17.5mm ✓
6	Inside Diameter	Drg. No.	520.12 mm ✓	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm ✓	
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		565mm ✓	
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 11/09/24

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

1	Counter Sinking Depth & Finish	OK							Row - 96
2	External Relief Dia	5.5mm	outside	Innel					
3	External Relief Depth	5mm ✓							
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		11	09	24				

Inspected By (Sign) & Date Ramanpreet Singh 11/09/24

11/09/24  
Reviewed by (Engineer-CNC)

Manager-QA