



# 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.		12877 ✓	33/53/79 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD 717
3	Pallet Die No.		12966 (6.0mm)	(Rev 01)
4	Die Category	Drg. No.	S: Jumbo ✓	✓
5	Out Side Diameter	Drg. No.	1008 44 ✓	Step length - 4/1mm
6	Inside Diameter	Drg. No.	850.12 44 ✓	Tap angle - 8°
7	Width of Pellet Die	Drg. No.	266 mm ✓	Under cot - 2.44
8	Grooves as per Drawing	Drg. No.	45x8x10 44 ✓	[8x10] 44 ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of
10	Drilling Area Surface Smoothness		ok	Holes ?
11	Tapping Operator		M/c Shop	[Both Side]
12	Tapping PCD		935 mm ✓	[Face Side Step
13	Tapping Hole Diameter		M 20 check by M 20 Bolt ✓	[2 44 Deep Bar
14	Tapping On Second Side	Half pitch of 1st side	ok	Side]
15	Tapping Hole Depth		Drill Depth - 42.5mm Tapping Depth - 40.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 13/09/24

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 - 30°

1	Counter Sinking Depth & Finish	ok						Row - 16
2	External Relief Dia	6.5 mm, 7.0 mm	6.5 mm	7.0 mm	All Rows			
3	External Relief Depth	✓	46 mm	26 mm	✓			
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		13	09	24			

### Inspected By (Sign) & Date

Ramanpreet Singh 13/09/24

14/09/24

Reviewed by (Engineer-CNC)

Manager-QA