



# 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.		12931	32/42/50
2	Machined By		V.T.L M/c Shop	Reg No ZSD 833
3	Pallet Die No.		11864 (4.0mm)	(REV0)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620mm	Step length-20mm
6	Inside Diameter	Drg. No.	520.12mm	Taper-10°
7	Width of Pellet Die	Drg. No.	186mm	Under wt-1.8mm
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		M16 check by M16 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 28/09/24

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-25
2	External Relief Dia	4.5, 5.0mm	4.5mm	5.0mm	All Rows		
3	External Relief Depth		18mm	8mm			
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		28	09	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 28/09/24

Reviewed by (Engineer-CNC)

Manager-QA