



# 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.		13379 ✓	35/50 ✓
2	Machined By		V.T.L Mic Shop	Drg No-2EC9980
3	Pallet Die No.		13147 (4.0mm)	Rev00 ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm	Step 00 Tapper-12°
6	Inside Diameter	Drg. No.	520/2mm ✓	Step length-18.5mm ✓
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		Mic 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 23/11/24

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

Country - Bot

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		19mm	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		23	11	24		

**Inspected By (Sign) & Date**

Ramanpreet Singh 23/11/24

Satyam 23/11/24

Reviewed by (Engineer-CNC)

Manager-QA