



# 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.		13197 ✓	55/67 ✓
2	Machined By		V.T.L M/c Shop	Drg No- LSD1117
3	Pallet Die No.		13797 (80mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680 mm ✓	Step length-32mm
6	Inside Diameter	Drg. No.	548 mm ✓	Under cut-4mm
7	Width of Pellet Die	Drg. No.	178mm ✓	
8	Grooves as per Drawing	Drg. No.	30x 7x8mm / 30x 7x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes ? Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		614mm	
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-35.4mm Tapping Depth-33.5mm	
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

Counter-30

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	9.0mm	All Rows				
3	External Relief Depth		12mm ✓				
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		P3	11	P4		

Inspected By (Sign) & Date Ramanpreet Singh 23/11/24

Satyam  
23/11/24

Reviewed by (Engineer-CNC)

Manager-QA