



# 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.		13294 ✓	P4/40 ✓
2	Machined By		V.T.L M/c SHOP	P29 No- Lark Sta
3	Pallet Die No.		R332 (3.5mm) ✓	9109 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm	Step of - 395mm Step length - 14.5mm
6	Inside Diameter	Drg. No.	320.12mm ✓	
7	Width of Pellet Die	Drg. No.	142mm ✓	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2mm / 15.5 x 7 x 2mm	
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		355mm ✓	
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 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

Count - 60

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	φu.c / outside		INNER			
3	External Relief Depth	20mm (R-2)		16mm			
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

Saty 23/11/24

Reviewed by (Engineer-CNC)

Manager-QA