



# 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.		11881 ✓	45/60 ✓
2	Machined By		V.T.L M/C Shop	Drg No LSD-584
3	Pallet Die No.		12299 (8.0mm)	Cherov ✓
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780mm, Stel of - 798mm	Taper - 4° ✓
6	Inside Diameter	Drg. No.	660.12 mm	Stel Length 25.5
7	Width of Pellet Die	Drg. No.	324mm ✓	Under Cut 9.0mm
8	Grooves as per Drawing	Drg. No.	21.5 X 8 X 10mm / 21.5 X 8 X 10mm	
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		725mm ✓	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth 31mm Tapping Depth - 28.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 20/5/2024

1	As per programme no.		—	2 Slot 32.1 mm Width 8mm Deep Both Side
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 - 27
2	External Relief Dia	8.5mm ✓	Outside (3-3)	Inner				
3	External Relief Depth		23mm ✓	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		20	5	24			

### Inspected By (Sign) & Date

Ramanpreet Singh 20/5/24

Sasouli 20/5/24

Reviewed by (Engineer-CNC)

Manager-QA