



# 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.		11985	36/50
2	Machined By		V.T.L M/C SHOP	Drg No - LSD 670
3	Pallet Die No.		11675	(Roc)
4	Die Category	Drg. No.	Jumbo (30mm)	
5	Out Side Diameter	Drg. No.	760mm	Step length 30mm
6	Inside Diameter	Drg. No.	660.12mm	Taper - 10°
7	Width of Pellet Die	Drg. No.	290mm	Under Cut - 21mm
8	Grooves as per Drawing	Drg. No.	27x8x7.4mm / 27.8x8x7.4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 12 Both Side]
11	Tapping Operator		M/C SHOP	
12	Tapping PCD		724mm	
13	Tapping Hole Diameter		M22 check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 30mm Tapping Depth - 27.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 21/5/24

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 / Hole close	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter - 60°  
Row - 48

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.5mm	Outside (3-3)	Innce			
3	External Relief Depth		20mm	14mm			
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		21	5	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 21/5/24

Sarjan 21/5/24

Reviewed by (Engineer-CNC)

Manager-QA