



# 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.		11898 ✓	26/77 ✓
2	Machined By		V.T.L M/C Shop	Drg No- LSD-1042
3	Pallet Die No.		R329 <del>1027</del> (6.0mm) ✓	(Rev 0)
4	Die Category	Drg. No.	S. Jumbo 22045-414 ✓	
5	Out Side Diameter	Drg. No.	1004 mm, Step od-1023 mm ✓	Step length-45mm ✓
6	Inside Diameter	Drg. No.	850.5 mm / 851.2 mm ✓	Taper-8 ✓
7	Width of Pellet Die	Drg. No.	266 mm ✓	Under cut-3.8mm ✓
8	Grooves as per Drawing	Drg. No.	45 X 6 X 10 mm / 45 X 6 X 10.2 mm ✓	12 X 10 mm ✓
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No. of
10	Drilling Area Surface Smoothness		ok	Holes 2
11	Tapping Operator		M/C Shop	Both side ✓
12	Tapping PCD		929 mm ✓	Face side Step
13	Tapping Hole Diameter		M20 Check by M20 Bolt	2mm Deep
14	Tapping On Second Side	Half pitch of 1st side	ok	Both side ✓
15	Tapping Hole Depth		Drill Depth-39mm Tapping Depth-35mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ramanpreet Singh 05/6/24	
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	
<b>Note : Mark the defective holes/Missed holes with the help of Permanent Marker</b> Counter-30 ✓				
1	Counter Sinking Depth & Finish	ok		Row-16
2	External Relief Dia	7.5 mm	ALL Rows	
3	External Relief Depth		51 mm ✓	
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		05 / 6 / 24	
Inspected By (Sign) & Date			Ramanpreet Singh 05/6/24	

Sat 5/6/24

Reviewed by (Engineer-CNC)

Manager-QA