



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11873 ✓	10/85 ✓
2	Machined By		V.T.L M/C Shop	Drg No- LSD 698
3	Pallet Die No.		11741 (4.0mm) ✓	(REV00) ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	610mm ✓	Step od- 632mm / 630.5
6	Inside Diameter	Drg. No.	48mm ✓	500mm ✓
7	Width of Pellet Die	Drg. No.	181mm ✓	Step length- 19mm / 15.5mm
8	Grooves as per Drawing	Drg. No.	34mm / 25mm ✓	Under Cut - 10.2mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		538mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	1 Side Tapping Hole & 2nd side Slot ✓	
15	Tapping Hole Depth		Drill Depth- 39mm Tapping Depth- 26.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanpreet Singh 08/6/24

1	As per programme no.		—	2 Slot 29.1mm Width 14mm Deep
2	Gun Drilling Work Completed On		—	
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		No 1 Hole close (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60°

1	Counter Sinking Depth & Finish	ok							Row- 21
2	External Relief Dia	4-5mm ✓	All	Rows					
3	External Relief Depth		55mm	Deep ✓					
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		08	6	24				

Inspected By (Sign) & Date Ramanpreet Singh 08/6/24

Reviewed by (Engineer-CNC)

Manager-QA