



# 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.		12083	40/60
2	Machined By		V.T.L M/C Shop	Drg No- LSP 654
3	Pallet Die No.		11562 (6.0mm)	(REV 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 600.12mm Stepod <del>19.2mm</del>	Step length- 19.5mm
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	36 X 10 X 7mm / 36 X 10 X 7mm	
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		645mm	
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 - 20.6mm Tapping Depth - 18.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

**Inspected By (Sign) & Date**

Ramanpreet Singh 13/06/24

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

Counter - 68  
Row - 16

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	7.0mm					
3	External Relief Depth		20mm	All Rows			
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		13	06	24		

**Inspected By (Sign) & Date**

Ramanpreet Singh 13/06/24

Satya 13/6/24

Reviewed by (Engineer-CNC)

Manager-QA