



# 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.		12084	55/65
2	Machined By		V.T.L M/C SHOP	Drg No - LSD 1066
3	Pallet Die No.		12074 (10.0mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	730mm Step od - 692mm	Step length - 18.5mm
6	Inside Diameter	Drg. No.	600.12mm	
7	Width of Pellet Die	Drg. No.	220mm	
8	Grooves as per Drawing	Drg. No.	12X7X7mm / 12X7X7mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of ]
10	Drilling Area Surface Smoothness		OK	[ Holes 12 ]
11	Tapping Operator		M/C SHOP	[ Both Side ]
12	Tapping PCD		644mm	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.5mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 21/06/24

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 - 600

Row - 13

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	11.0mm	10.0mm				
3	External Relief Depth		10.0mm	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		21	06	24		

Inspected By (Sign) & Date

Ramanpreet Singh 21/06/24

Sats  
21/06/24

Reviewed by (Engineer-CNC)

Manager-QA