



# 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.		12050	28/36/86
2	Machined By		V.T.L M/C Shop	Drg No-LSD 609
3	Pallet Die No.		12490 (6.0mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo 3200Vt - 4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	Step of - 693mm	Taper - 8
7	Width of Pellet Die	Drg. No.	548.14mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	195mm	
9	Fitting Sizes on CNC Plate	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm - 4 X 8mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 4 Both Side
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		619mm	Face Step
14	Tapping On Second Side	Half pitch of 1st side	M16 Check by M16 Bolt	2mm Deep
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth - 35mm Tapping Depth - 32mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

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 - 30°

1	Counter Sinking Depth & Finish	ok						Row - 12
2	External Relief Dia	6.5mm, 7.0mm	6.5mm	7.0mm				
3	External Relief Depth		4.0mm	3.0mm	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		15	06	24			

Inspected By (Sign) & Date Ramanpreet Singh 15/06/24

*Satya*  
15/6/24

Reviewed by (Engineer-CNC)

Manager-QA