



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7747

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.		11216	27/47
2	Machined By		V.T.L M/C Shop	Dwg No - LEC 21897
3	Pallet Die No.		11621 (3.0mm)	(Revo)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	614mm	Step length - 21.5mm/21.8mm
6	Inside Diameter	Drg. No.	570.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	222mm	Under cut - 3.75mm
8	Grooves as per Drawing	Drg. No.	13X8X5mm / 13X8X5mm	
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		565mm	
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 - 21.3mm Tapping Depth - 19mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanjeet Singh 28/06/24

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 - 60°

1	Counter Sinking Depth & Finish	OK						Row-37
2	External Relief Dia	3.5mm	outside (3.3)	Inner				
3	External Relief Depth		23mm	20mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		28	06	24			

### Inspected By (Sign) & Date

Ramanjeet Singh 28/06/24

*[Signature]*  
28/6/24

reviewed by (Engineer-CNC)

Manager-QA