



# Lark Engineering Company (India) Pvt. Ltd.

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

7/100  
 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.		12296	50/50
2	Machined By		V.T.L M/C Shop	Drg No. - LEC 13760
3	Pallet Die No.		12370 (8.0mm)	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	580mm Step 02 = 491mm	Step length = 17.5
6	Inside Diameter	Drg. No.	420.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm   12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20 - Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.3mm	Tapping Depth = 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/7/24

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

1	Counter Sinking Depth & Finish	ok							Counter = 60° Row = 12
2	External Relief Dia	8.5mm	outside (2-2)		Inner				
3	External Relief Depth		4mm		Mill				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		3	7	24				

Inspected By (Sign) & Date Ravi 31/7/24

Ravi  
31/7/24  
Reviewed by (Engineer-CNC)

Manager-QA