



# 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.			
2	Machined By		12217	40/55
3	Pallet Die No.		V.T.L M/C Shop	Drg No-LSP/1078
4	Die Category	Drg. No.	12784 (4.0mm)	(REV 00)
5	Out Side Diameter	Drg. No.	SEW	
6	Inside Diameter	Drg. No.	530mm Step od- 499mm	Step length-17mm
7	Width of Pellet Die	Drg. No.	420.12mm	Taper-12°
8	Grooves as per Drawing	Drg. No.	182mm	
9	Fitting Sizes on CNC Plate	Drg. No.	10x8x3mm / 10x8x3mm	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 8 Both Side
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		454mm	
14	Tapping On Second Side	Half pitch of 1st side	3/4 Check by 3/4 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth- 18.4mm Tapping Depth- 16.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date Ramanpreet Singh 29/06/24

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

1	Counter Sinking Depth & Finish	OK						Counter-60°
2	External Relief Dia	4.5mm	outside (2-2)	Inner				Row-26
3	External Relief Depth		18mm	15mm				
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		29	06	24			

Inspected By (Sign) & Date Ramanpreet Singh 29/06/24

Reviewed by (Engineer-CNC) Satyajit 29/06/24

Manager-QA