



# 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.		11555	36/50
2	Machined By		V.T.L M/C Shop	Dwg No - LSD 450
3	Pallet Die No.		11878 (4.0mm)	(REV 00)
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm	Step length - 23mm
6	Inside Diameter	Drg. No.	630.12mm	Taper - 10°
7	Width of Pellet Die	Drg. No.	290mm	Under cut - 6.75mm
8	Grooves as per Drawing	Drg. No.	15 X 8 X 5mm / 15 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	Tapping No. of Holes 16 Both side
11	Tapping Operator		M/C Shop	
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M 20 check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanjeet Singh 05/07/24	
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	
<b>Note : Mark the defective holes/missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Counter - 8.5° Row - 43
2	External Relief Dia	4.5mm	outside (3-2) Inner	
3	External Relief Depth		18mm, 14mm	
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		05 07 24	
Inspected By (Sign) & Date			Ramanjeet Singh 05/07/24	

Reviewed by (Engineer-CNC)

Manager-QA