

# 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.		12247	28/38/66 ✓
2	Machined By		V.T.L M/c shop	Drg No- LSD 609
3	Pallet Die No.		12799 (60mm)	(REVOL)
4	Die Category	Drg. No.	M. Jumbo 2200vc-4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm Step of- 693mm	Step Length- 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper- 8° 31.3
7	Width of Pellet Die	Drg. No.	195mm	Under cut- 2.5mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x7.8mm	4x8mm
9	Fitting Sizes on CNC Plate	Drg. No.	✓ OK ✓ (D)	[ Tapping No. of ]
10	Drilling Area Surface Smoothness		OK	[ Holes 4 ]
11	Tapping Operator		M/c shop	[ Both Side ]
12	Tapping PCD		619mm	Face side step
13	Tapping Hole Diameter		M16 check by M16 Bolt	2mm Deep
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	Both Side
15	Tapping Hole Depth		Drill Depth- 35mm Tapping Depth-	32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 08/07/24

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	

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	7.0mm			
3	External Relief Depth	✓ ✓	38mm	All Rows	38mm	28mm		
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		08	07	24			

Inspected By (Sign) & Date Ramanpreet Singh 08/07/24

Reviewed by (Engineer-CNC)

Manager-QA