



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		12305	21/40
2	Machined By		V.T.L M/c Shop	Reg No-LSL 21
3	Pallet Die No.		11843 (2.8mm)	(REV 01)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length-17mm
6	Inside Diameter	Drg. No.	420.12mm	Taper-12°
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	Tapping No. of Holes & Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		3/4" check by 3/4" Belt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth-18.4mm Tapping Depth-16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanjeet Singh 15/07/24

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 2 Hole close

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter-60°

1	Counter Sinking Depth & Finish	OK						Row-26
2	External Relief Dia	3.3mm	outside (2-2)	Inner				
3	External Relief Depth		22mm	19mm				
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		15	07	24			

### Inspected By (Sign) & Date

Ramanjeet Singh 15/07/24

Satya 16/7/24

Reviewed by (Engineer-CNC)

Manager-QA