



# 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.		12445	45/50
2	Machined By		V.T.L M/C Shop	Drg No - LEC 12501
3	Pallet Die No.		12540 (3-8mm)	(REV 01)
4	Die Category	Drg. No.	M Jumbo	
5	Out Side Diameter	Drg. No.	700mm	Step length - 20mm
6	Inside Diameter	Drg. No.	Step OD - 693mm	Tapper - 12°
7	Width of Pellet Die	Drg. No.	600-12mm	
8	Grooves as per Drawing	Drg. No.	1 222mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 X 8 X 7mm / 12 X 8 X 7mm	
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 12 Both Side
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		640mm	
14	Tapping On Second Side	Half pitch of 1st side	M 20 check by M 20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm Tapping Depth - 13.5mm	
17	Visual Inspection Before Gun Drilling		Yes	
			ok	

### Inspected By (Sign) & Date

Ramanpreet Singh 24/07/24

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

1	Counter Sinking Depth & Finish	ok							Counter - 60°
2	External Relief Dia	4.3mm	outside (3-3)	inner					Row - 33
3	External Relief Depth		9mm	5mm					
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		24	07	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 24/07/24

Reviewed by (Engineer-CNC)  
Sanyal 24/7/24

Manager-QA