



# 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.		12482	28/50
2	Machined By		V.T.L M/C Shop	Dwg No-LEC 9980
3	Pallet Die No.		1190 (2.8mm)	(REV00)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	620mm	Step of Tapper-12°
6	Inside Diameter	Drg. No.	520.12mm	Step length-13.5mm
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5mm / 13 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No of Holes 12 Both Side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 check by M20 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 Ramanpreet Singh 13/07/24

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 1 Hole close (A)

Note : Mark the defective holes/missed holes with the help of Permanent Marker Counter-60° Row-40

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	3.3mm	outside (3-3)	Inner			
3	External Relief Depth		25mm	22mm			
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		13	07	24		

Inspected By (Sign) & Date Ramanpreet Singh 13/07/24

Satyan  
13/7/24