



# 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.		<del>12778</del> 12619	45/52
2	Machined By		V.T.L M/c Shop	Drg No- LSD1118
3	Pallet Die No.		1986 (80mm)	(REV00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	734mm, Std of- 733.3mm	Step length- 22.5mm
6	Inside Diameter	Drg. No.	63.12mm	Taper- 12°
7	Width of Pellet Die	Drg. No.	250mm	
8	Grooves as per Drawing	Drg. No.	17x8x7mm / 17x8x7mm	
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		680mm	
13	Tapping Hole Diameter		M to check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth- 25.4mm Tapping Depth- 23.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 25/08/24

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	8.5mm	Outside (33)	Inner				POW- 20
3	External Relief Depth		15mm	7mm				
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		25	08	24			

Inspected By (Sign) & Date Ramanpreet Singh 25/08/24

Reviewed by (Engineer-CNC) [Signature] 26/08/24

Manager-QA