



# 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.		1P746	39/44/50
2	Machined By		V.T.C M/c Shop	Drj No - LSD 493
3	Pallet Die No.		1P548 (3.0mm)	(Rev00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700mm	Step length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Taper - 1°
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	12x10x7.5mm / 12x10x7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No. of Holes R Both Side ]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		640mm	
13	Tapping Hole Diameter		M 20 check by M 20 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 03/09/24

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 - 60

1	Counter Sinking Depth & Finish	ok							Row - 38
2	External Relief Dia	3.5, 4.0mm	3.5mm	4.0mm					All Rows
3	External Relief Depth		11mm	6mm					
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		03	09	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 03/09/24

Reviewed by (Engineer-CNC)

Satyam 31/9/24

Manager-QA