



# 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.			
2	Machined By		INV 1012919	30/50 ✓
3	Pallet Die No.		V.T.C M/c Shop	Dwg No - LEC 9980
4	Die Category	Drg. No.	12833 (3.0mm)	(REV 00)
5	Out Side Diameter	Drg. No.	SSEW	✓
6	Inside Diameter	Drg. No.	620mm	Step of Tapper 12°
7	Width of Pellet Die	Drg. No.	548.12mm	Step Length - 18.5mm
8	Grooves as per Drawing	Drg. No.	222mm	✓
9	Fitting Sizes on CNC Plate	Drg. No.	13X8X5mm / 13X8X5mm	
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		565mm ✓	
14	Tapping On Second Side	Half pitch of 1st side	M20 Check by M20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth - 20.4mm	Tapping Depth - 18.5mm
17	Visual Inspection Before Gun Drilling		Yes	✓

### Inspected By (Sign) & Date

Ramanpreet Singh 14/09/24

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	
4	Defective Holes (If Any)		ok No 2 Hole close

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

1	Counter Sinking Depth & Finish	ok							Counter-60° Pow-38
2	External Relief Dia	3.5mm	Outside (3-3)	Inner					
3	External Relief Depth	✓	23mm	20mm					
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		14	09	24				

### Inspected By (Sign) & Date

Ramanpreet Singh 14/09/24

Satya 14/9/24  
 Reviewed by (Engineer-CNC)

Manager-QA