



# 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.		12918 ✓	30/66 ✓
2	Machined By		V.T.L. H/C Shop	Drg No. 1-3.0-609
3	Pallet Die No.		12949 (6.0) mm ✓	Rev = 01
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 ✓ Step OD 692 mm	Tapper 2.8
6	Inside Diameter	Drg. No.	548.1 mm ✓	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm ✓	Under cut 2.5 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 mm   32 x 7 x 8 mm (4x8) mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2 mm Deep Both Side
11	Tapping Operator		H/C Shop	Tapping No. of holes 9
12	Tapping PCD		619 mm	Both Side
13	Tapping Hole Diameter		M16 ✓ Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 34.8 mm	Tapping Depth 32
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 20/9/24

FD Fitting

1	As per programme no.		—————	Size in final
2	Gun Drilling Work Completed On		—————	Acc. to LSD 609
3	Hole Finish In Gun Drilling	Marked	ok	Rev = 02
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 30°
2	External Relief Dia	7.0 mm	All Rows				Rep = 12
3	External Relief Depth		36 mm				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		20	9	24		

### Inspected By (Sign) & Date

Ravi 20/9/24

Satyam  
20/9/24  
Reviewed by (Engineer-CNC)

Manager-QA