



# 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.		12886 ✓	
2	Machined By		U7L MLC Sharp	46/68 ✓
3	Pallet Die No.		12813 (C <sub>3</sub> 3.8) mm	Drill in G93 Rego
4	Die Category	Drg. No.	2400/20	
5	Out Side Diameter	Drg. No.	829.5 mm	OD Step - 823 mm
6	Inside Diameter	Drg. No.	700 mm	OD Step height - 3.3
7	Width of Pellet Die	Drg. No.	324 mm	Cooper 4°
8	Grooves as per Drawing	Drg. No.	30 X 8 X 8.5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Sharp	Tapping Hoop
12	Tapping PCD		760 mm	Hole - 12
13	Tapping Hole Diameter		M22 Check M22 Bolt	Both set
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drilling Depth - 36.2 mm	Tapping Depth - 35 mm
16	Perpendicularity of Tapped Hole		7/1	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

*[Signature]* 8/11/24

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					
2	External Relief Dia	24.3	outside	inner			
3	External Relief Depth		27 mm	(3-3)	19 mm		
4	Inspection Done Before Hardening By (Name)		Sanjeev				
5	Material Sent For Hardening By (Name)		Hark Puram				
6	Material Sent For Hardening On Date		8	11	24		

### Inspected By (Sign) & Date

*[Signature]* 8/11/24

Reviewed by (Engineer-CNC)

Manager-QA