



# 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)

8557

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13226 ✓	30/45/55/
2	Machined By		VTL M/c Shop	Drw No - LSD 340
3	Pallet Die No.		12924 (6.0mm)	(Rev 00)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	690 mm OD Step - 682 mm	Step length - 31.5 mm
6	Inside Diameter	Drg. No.	580 mm	coplan 12°
7	Width of Pellet Die	Drg. No.	266 mm ✓	
8	Grooves as per Drawing	Drg. No.	28.5 x 6 x 12 mm / 28.5 x 6 x 12 mm	
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		630 mm ✓	
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 - 25.4 mm Tapping Depth - 23.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

*[Signature]* 17/11/24

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

Counter-60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5 mm, 7.0 mm	6.5 mm	7.0 mm	All Rows		
3	External Relief Depth		25 mm ✓	10 mm			
4	Inspection Done Before Hardening By (Name)		<i>[Signature]</i>				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		16	16	24		

### Inspected By (Sign) & Date

*[Signature]* 17/11/24

Reviewed by (Engineer-CNC)

Manager-QA