



# 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.		1981	P6/34/105 / 36/44/105
2	Machined By		V.T.L Mic Shop	Drg No - LSD 1190
3	Pallet Die No.		14055 (8.0mm)	Rev 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	OD-1059.5, Step OD-1077mm	Step length - 4Rmm
6	Inside Diameter	Drg. No.	1 <sup>st</sup> Side - 848mm 2 <sup>nd</sup> Side 846.5mm	Tapper - 8"
7	Width of Pellet Die	Drg. No.	966mm	
8	Grooves as per Drawing	Drg. No.	45x 8x 9.2 / 45x 8x 9.2mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 2 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		Mic Shop	
12	Tapping PCD		952mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 42.4mm Tapping Depth - 40.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 29/11/24

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 - 30°

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	7.0mm, 7.5mm	7.0mm 1 <sup>st</sup> Pad	7.5mm 2 <sup>nd</sup> Pad	7.5mm 1 <sup>st</sup> Pad	7.5mm 2 <sup>nd</sup> Pad	
3	External Relief Depth		79mm	71mm	89mm	61mm	
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		29	11	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 29/11/24

Satya 29/11/24

Reviewed by (Engineer-CNC)

Manager-QA