



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13720	41/60
2	Machined By		V.T.L. n/c Shop	Dy No. 1.8.0 = 586
3	Pallet Die No.		13983 (3.8)	Rev = 00
4	Die Category	Drg. No.	Tombo	
5	Out Side Diameter	Drg. No.	780mm Step 00 = 800mm	Tappers 10°
6	Inside Diameter	Drg. No.	660.1mm	Step length 30mm
7	Width of Pellet Die	Drg. No.	290mm	Under cut = 1mm
8	Grooves as per Drawing	Drg. No.	27 x 8 x 7.4mm / 27 x 8 x 7.4mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Bolt Side
12	Tapping PCD		724mm	
13	Tapping Hole Diameter		M22 = Check by M22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 29.2mm	Tapping Depth 27.6mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 28/12/24

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					Counter 60°
2	External Relief Dia	4.3mm	Outside (3-3)		Inner		Row 60
3	External Relief Depth		24mm		20mm		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		28	12	24		

### Inspected By (Sign) & Date

Ravi 28/12/24

Satya 28/12/24  
Reviewed by (Engineer-CNC)

Manager-QA