



# 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.		12045	38/50
2	Machined By		V.T.L M/C Shop	Drg No - LSP-405
3	Pallet Die No.		12310 (4.0mm)	(R00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520 mm Step 02 - 499	Step length = 17 mm
6	Inside Diameter	Drg. No.	420.12 mm	Tapper = 12°
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm   12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 8 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 19 mm Tapping Depth - 16.8 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

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						Row - 20
2	External Relief Dia	4.5 mm	outside (2-2)	Inner				
3	External Relief Depth		16 mm	12 mm				
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		29	5	24			

### Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

Reviewed by (Engineer-CNC)

Manager-QA