



# 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.		12146	40/66
2	Machined By		V.T.L MIC Shop	Drg No-2SP-609
3	Pallet Die No.		11915 (6.0mm)	(Rev'd)
4	Die Category	Drg. No.	M. Jumbo	odg 200V 4X3
5	Out Side Diameter	Drg. No.	680.7mm	Step length - 31mm
6	Inside Diameter	Drg. No.	548.12mm	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Undercut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32X7X8mm / 32X7X9mm	4X8
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. OK
10	Drilling Area Surface Smoothness		OK	Holes 4
11	Tapping Operator		MIC Shop	Both Side
12	Tapping PCD		619mm	Face Step - 2mm
13	Tapping Hole Diameter		M16 check by M16 Bolt	Deep Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 33.8mm Tapping Depth - 31.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanjeet Singh 01/6/24

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							Row-12
2	External Relief Dia	7.3mm	outside (3-3)	Inner	All holes				
3	External Relief Depth		26mm						
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		01	6	24				

Inspected By (Sign) & Date Ramanjeet Singh 01/6/24

Satya 11/6/24

Reviewed by (Engineer-CNC)

Manager-QA