



# Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7642

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.		11814	33/50
2	Machined By		V.T.L M/C Shop	Drg No - LSP 450
3	Pallet Die No.		11879 (3-0mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo EW	
5	Out Side Diameter	Drg. No.	730mm	Step length - 23mm
6	Inside Diameter	Drg. No.	630.12mm	Tapped - 10°
7	Width of Pellet Die	Drg. No.	290mm	Undercut - 6.75mm
8	Grooves as per Drawing	Drg. No.	15 X 8 X 5mm / 15 X 8 X 5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[ Tapping No. of Holes 16 Both Side ]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		685mm	
13	Tapping Hole Diameter		M 20 Check by M 20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 20.7mm Tapping Depth - 18.7mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanpreet Singh 11/06/24

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°  
Row - 52

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.5mm	Outside (3-3)	Inner			
3	External Relief Depth		23mm	17mm			
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		11	06	24		

### Inspected By (Sign) & Date

Ramanpreet Singh 11/06/24

Signature  
11/06/24

Reviewed by (Engineer-CNC)

Manager-QA