



# Lark Engineering Company (India) Pvt. Ltd.

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

7649  
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.		12104	53/58
2	Machined By		V.T.L M/C Shop	Drg No - LEC-8986
3	Pallet Die No.		12495 (3.8mm)	(Rev 00)
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	776mm	Step length - 26mm
6	Inside Diameter	Drg. No.	660.12mm	Under cut - 12mm
7	Width of Pellet Die	Drg. No.	316mm	
8	Grooves as per Drawing	Drg. No.	20 X 8 X 7.5mm / 20 X 8 X 7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping No. of Holes 12]
11	Tapping Operator		M/C Shop	[Both Side]
12	Tapping PCD		725mm	
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 - 25.5mm Tapping Depth - 23.6mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 12/06/24

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 1 Hole close (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker Counter - 60° Row - 47

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.3mm	outside (3-3)	Inner			
3	External Relief Depth		12mm	5mm			
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		12	06	24		

Inspected By (Sign) & Date Ramanpreet Singh 12/06/24

Reviewed by (Engineer-CNC)

Manager-QA