



# Lark Engineering Company (India) Pvt. Ltd.

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

7650

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.		12187 ✓	36/66
2	Machined By		V.T.L M/C Shop	Drg No - LSD 609
3	Pallet Die No.		12250 (10.0 mm)	(Revol)
4	Die Category	Drg. No.	M. Jumbo groove - 4x3mm	
5	Out Side Diameter	Drg. No.	680.7mm Step od - 693mm	Step Length - 31mm
6	Inside Diameter	Drg. No.	548.14mm Base	549mm
7	Width of Pellet Die	Drg. No.	195mm	Tapper - 8 under cut - 2.5mm 4x8mm
8	Grooves as per Drawing	Drg. No.	32x7x8mm / 32x7x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[ Tapping No. of ]
10	Drilling Area Surface Smoothness		ok	Holes 4
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619mm	Face Side Step
13	Tapping Hole Diameter		M 16 check by M 16 Bolt	2mm Deep Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 35mm Tapping Depth	32mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ramanjeet 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

Note : Mark the defective holes/missed holes with the help of Permanent Marker Counter - 30° Row - 8

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	11.0 mm					
3	External Relief Depth	30 mm	All Rows				
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	12	06	24			

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

Satya 12/6/24

Reviewed by (Engineer-CNC)

Manager-QA