



# 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.		12218	40/50
2	Machined By		V.T.L M/c Shop	Drg No - LSD 21
3	Pallet Die No.		12327	(REV 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm	Step length - 17mm
6	Inside Diameter	Drg. No.	420.12mm	Taper - 12°
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 X 8 X 3mm / 12 X 8 X 3mm	
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 - 21.3mm Tapping Depth - 19.4mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

### Inspected By (Sign) & Date

Ramanjeet Singh 24/06/24

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 - 6°

1	Counter Sinking Depth & Finish	OK							Row - 20
2	External Relief Dia	4.5mm	outside (2-2)	Inner					
3	External Relief Depth		14mm	10mm					
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		24	06	24				

### Inspected By (Sign) & Date

Ramanjeet Singh 24/06/24

Satya 24/6/24

Reviewed by (Engineer-CNC)

Manager-QA