



# 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.		12307	33/50
2	Machined By		V.T.L M/C Shop	Drg No - LarkStd
3	Pallet Die No.		10850 (3.0mm)	6355
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	619.9 mm / Step od - 612 mm	Step length - 19.5 mm
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13 X 8 X 5 mm / 13 X 8 X 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 12 Both Side
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		565 mm	
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 - 20.4 mm Tapping Depth - 18.5 mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ramanpreet 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 - 60°				
1	Counter Sinking Depth & Finish	OK		Roll - 38
2	External Relief Dia	3.3 mm	outside (3-3) Inner	
3	External Relief Depth		23 mm / 17 mm	
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		24 / 06 / 24	
Inspected By (Sign) & Date			Ramanpreet Singh 24/06/24	

Reviewed by (Engineer-CNC) *Satya 24/6/24*

Manager-QA