



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.		19650 ✓	33/50 ✓
2	Machined By		V.T.L M/c Shop	Dr. No - LSD 60°
3	Pallet Die No.		11858 (30mm)	(Rev 00) ✓
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	620.4mm Step 00-624mm	Step length - 20mm
6	Inside Diameter	Drg. No.	520.12mm	Tapper 12°
7	Width of Pellet Die	Drg. No.	182mm	Under cut 1.8mm
8	Grooves as per Drawing	Drg. No.	12x10x5mm / 12x10x5mm	
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		565mm ✓	
13	Tapping Hole Diameter		M16 Check by M16 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

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								Row - 29 ✓
2	External Relief Dia	3.3mm	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		24	08	24					

Inspected By (Sign) & Date

Ramanpreet Singh 24/08/24

[Signature]
24/8/24

Reviewed by (Engineer-CNC)

Manager-QA