



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		19808	36/45
2	Machined By		V.T.L M/c Shop	Drg No - LSD 579
3	Pallet Die No.		13076 (3.0mm)	(Revol)
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	61mm Step Od - 615.5mm	Step Length - 20mm
6	Inside Diameter	Drg. No.	50.1mm	Taper - 4°
7	Width of Pellet Die	Drg. No.	222mm	Under cut - 2.75mm
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Tapping No. of Holes 12]
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	[Both Side]
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.4mm Tapping Depth - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

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 - 38
2	External Relief Dia	3-5mm	outside (3-3)	Inner						
3	External Relief Depth		15mm	9mm						
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		09	09	24					

Inspected By (Sign) & Date

Ramanpreet Singh 09/09/24

Signature
09/09/24

Reviewed by (Engineer-CNC)

Manager-QA