



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.		12933 ✓	34/50 ✓
2	Machined By		V.T.C M/c Shop	Drg No - 15P 633
3	Pallet Die No.		11865 (4.0mm)	(Rev 01)
4	Die Category	Drg. No.	SSSTP	
5	Out Side Diameter	Drg. No.	620mm	STEP OP - 623.6mm
6	Inside Diameter	Drg. No.	520.12mm	STEP LENGTH - 20mm
7	Width of Pellet Die	Drg. No.	186mm	Tapper 12°
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	Under cut - 1.8mm
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		M/c check check by M/c Bell	
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 28/09/24

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 - 25
2	External Relief Dia	4.5mm	Outside (3-3)	Inner						
3	External Relief Depth		20mm	16mm						
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		28	09	24					

Inspected By (Sign) & Date

Ramanpreet Singh 28/09/24

Reviewed by (Engineer-CNC)

Manager-QA