



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.		INV ✓	39/50 ✓
2	Machined By		V.T.L M/C SHOP	Drg No - LarkStd
3	Pallet Die No.		1R179 (3.5mm) ✓	1355 ✓
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	120mm Step OD - 612mm	Step Length - 19.5mm
6	Inside Diameter	Drg. No.	520.14mm ⊕	
7	Width of Pellet Die	Drg. No.	222mm ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm ✓	
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		M20 Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 20.9mm Tapping Depth - 187mm	
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

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 - 35
2	External Relief Dia	3.8mm	outside (3-3)	Inner					
3	External Relief Depth		18mm	11mm					
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		29	5	24				

Inspected By (Sign) & Date

Ramanjeet Singh 29/5/24

Satish 29/5/24

Reviewed by (Engineer-CNC)

Manager-QA