



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)

8550

S.No.	Check Parameter	Specifcation	Observations	Remarks
1	Work Order No.		13P78 ✓	4P/50/
2	Machined By		V.T/L M/c Shop	Dr. No - 13P78 (CR)
3	Pallet Die No.		1187P (3.5mm) ✓	
4	Die Category	Drg. No.	SSTP	
5	Out Side Diameter	Drg. No.	6P4mm Step OD - 6P4mm	Step length - 20mm
6	Inside Diameter	Drg. No.	58.12mm	Tapped - 1P
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	13X 8X 3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 1P 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 - 20.4mm Tapping Drill - 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanpreet Singh 16/11/24

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

Counts 60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	Outside (3-3)	Inner			
3	External Relief Depth		15mm	8mm			
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		16	11	24		

Inspected By (Sign) & Date

Ramanpreet Singh 16/11/24

Satinder 15/11/24

Reviewed by (Engineer-CNC)

Manager-QA