



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)

8605

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13324	39/50 ✓
2	Machined By		V.T.L M/c Shop	Part No- 9980
3	Pallet Die No.		1339P (3.0mm)	Rev 00 ✓
4	Die Category	Dr. No.	SSEW	
5	Out Side Diameter	Dr. No.	60mm Step OD Taper 17°	Step length- 18.5mm
6	Inside Diameter	Dr. No.	50-10mm	
7	Width of Pellet Die	Dr. No.	100mm	
8	Grooves as per Drawing	Dr. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Dr. 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 20.4mm Tapping depth 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramapreet Singh 23/11/24

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

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.3mm	outside 1.3mm	inner 2mm			
3	External Relief Depth		17mm	11mm			
4	Inspection Done Before Hardening By (Name)		Ramapreet Singh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		23	11	24		

Inspected By (Sign) & Date

Ramapreet Singh 23/11/24

Signature
23/11/24

Reviewed by (Engineer-CNC)

Manager-QA