



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 to 13138	45/50
2	Machined By		V.T.L n/a Shop	Dy. No. L.E.C. 970
3	Pallet Die No.		13114 (5.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	6.20 mm Step on Tapper 12°	
6	Inside Diameter	Drg. No.	5.20 ± 0.12 mm	Step length 18.5 mm
7	Width of Pellet Die	Drg. No.	22.8 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/a Shop	Tapping No. of Holes 12 Bottom Side
12	Tapping PCD		56.5 mm	
13	Tapping Hole Diameter		M2.2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 9/10/24

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, Go

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	5.3 mm	Outside (3-3)		Inner				
3	External Relief Depth		10 mm		5 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		9	10	24				

Inspected By (Sign) & Date

Raw: 9/10/24

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Reviewed by (Engineer-CNC)

Manager-QA