



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.		13010 ✓	38/50 ✓
2	Machined By		V.T.L. H/O Shop	Drg. No. L.E.C. 998
3	Pallet Die No.		13143 (3.0) ✓	Rev. 200
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	6.20 mm ✓	Step 0.2 Tapper 12°
6	Inside Diameter	Drg. No.	5.20.12 mm ✓	Step length = 18.5
7	Width of Pellet Die	Drg. No.	2.22 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		H/O Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		565 mm ✓	
13	Tapping Hole Diameter		H2 = 2 Check by H20 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

Ravi 11/10/24

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 - 1 Hole Colused

Note : Mark the defective holes/missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK					Counters → 60° Ravi 2/28
2	External Relief Dia	3.5 mm ✓	Outside (3-3)		Inner		
3	External Relief Depth		18 mm ✓		12 mm ✓		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Forance
6	Material Sent For Hardening On Date		11	10	24		

Inspected By (Sign) & Date

Ravi 11/10/24

Reviewed by (Engineer-CNC)
Saty 11/10/24

Manager-QA