



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		13068 ✓	35/55 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Dry Hole 1.2. Col 1952 ✓
4	Die Category	Drg. No.	12429 (B-0) n/c ✓	Rev 2.00 ✓
5	Out Side Diameter	Drg. No.	2x29mm	
6	Inside Diameter	Drg. No.	630mm Step 002 620.8mm ✓	Tabber 2.12 ✓
7	Width of Pellet Die	Drg. No.	520.12mm ✓	Step length 18.5 ✓
8	Grooves as per Drawing	Drg. No.	222mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	14x8x10mm 14x8x10mm ✓	
10	Drilling Area Surface Smoothness		ok ✓	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm ✓	Tapping n/c of Hole 2.12 Both Side
13	Tapping Hole Diameter		M20 Check by M2 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok ✓	
15	Tapping Hole Depth		Drill Depth 20.4mm ✓	Tapping Depth 18.5 ✓
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		ok ✓	

Inspected By (Sign) & Date

Ravi 18/10/24

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

1	Counter Sinking Depth & Finish	ok						Counter 60
2	External Relief Dia	6.5mm	Outside (3-3)		Inner			Rate 23
3	External Relief Depth		26mm		20mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		18	10	24			

Inspected By (Sign) & Date

Ravi 18/10/24

Reviewed by (Engineer-CNC)

Manager-QA