



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.			
2	Machined By		13126 ✓	34/50 ✓
3	Pallet Die No.		V.T.L. H/c Shop	Drg No. L-80-419
4	Die Category	Drg. No.	12561 (4.0) ✓	Rev. 09 ✓
5	Out Side Diameter	Drg. No.	M. Jumbo ✓	
6	Inside Diameter	Drg. No.	700 H/c ✓	Step 00.69 H/c ✓
7	Width of Pellet Die	Drg. No.	600.12 H/c ✓	Step length 9.5 ✓
8	Grooves as per Drawing	Drg. No.	222 H/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 H/c / 12.5 x 8 x 7 H/c ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		645 H/c ✓	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		M2 x 2 Check by M2 B. 11 ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 22.4 H/c ✓	Tapping Depth: 22.5 ✓
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/10/24

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 - 3 Hole Closed (A)

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

Counter = 60 ✓

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	11.5 H/c ✓	outside (3-3)		Inner				
3	External Relief Depth		20 H/c ✓		16 H/c ✓				
4	Inspection Done Before Hardening By (Name)				Ravi ✓				
5	Material Sent For Hardening By (Name)				Lark Ramesh				
6	Material Sent For Hardening On Date		22	10	24				

Inspected By (Sign) & Date

Ravi. 22/10/24

Reviewed by (Engineer-CNC)

Manager-QA