



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.		13142 ✓	44/50 ✓
2	Machined By		V.T.L. n/c. Shop	Dy. Insp. Lark 3370 ✓
3	Pallet Die No.		12824 (4.0) ✓	
4	Die Category	Dr. No.	Ext. inside	
5	Out Side Diameter	Dr. No.	62.44 ✓ Step 0.02 812.44 ✓	Step length 19.54 ✓
6	Inside Diameter	Dr. No.	52.12 ✓	
7	Width of Pellet Die	Dr. No.	22.2 ✓	
8	Grooves as per Drawing	Dr. No.	13x8x5 ✓ / 13x8x5 ✓	
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		56.5 ✓	[Tapping No of holes = 12 Back Side]
13	Tapping Hole Diameter		M2x2 Check by M2x Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 ✓	Tapping Depth = 8.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/10/24

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 - 60°

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 ✓	outside (3-3)		inner				
3	External Relief Depth		14 ✓		6 ✓				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Rosnace				
6	Material Sent For Hardening On Date		25	10	24				

Inspected By (Sign) & Date

Ravi 25/10/24

Ravi 25/10/24

Reviewed by (Engineer-CNC)

Manager-QA