



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		13240	33/50
3	Pallet Die No.		V.T.C. n/c Shop	Drg No. 20998
4	Die Category	Drg. No.	13150(3.0) n/c	Rev 2.0
5	Out Side Diameter	Drg. No.	6.20 mm	Step 0.2
6	Inside Diameter	Drg. No.	5.20-12 mm	Tapping 12
7	Width of Pellet Die	Drg. No.	2.22 mm	Step length 18.5
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		5.65 mm	
14	Tapping On Second Side	Half pitch of 1st side	n/c Check by H20 Ball	Tapping No. of holes Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 mm	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes	

Inspected By (Sign) & Date

Ravi 11/11/24

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	3.3 mm	Outside (3-2)		Inner			Rev 2.38
3	External Relief Depth		2.3 mm		1.7 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Burnace
6	Material Sent For Hardening On Date			11	11	24		

Inspected By (Sign) & Date

Ravi 11/11/24

11/11/24

Reviewed by (Engineer-CNC)

Manager-QA