



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.		13347 ✓	45/50
2	Machined By		V.T.L. n/c Shop	Drg. No. 1.25.1.998
3	Pallet Die No.		13146 (5.0) n/c ✓	Row 100
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 n/c, Step OD, Tapper 12°	Step length = 18.5
6	Inside Diameter	Drg. No.	520.12 n/c ✓	
7	Width of Pellet Die	Drg. No.	222 n/c ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes 12 Both side
12	Tapping PCD		565 n/c ✓	
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 n/c Tapping Depth = 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/11/24

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

Counter = 60
Row = 28

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.3 n/c ✓	Outside (3-3)		Inner		
3	External Relief Depth		10 n/c ✓		5 n/c ✓		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		25	11	24		

Inspected By (Sign) & Date

Ravi 25/11/24

Sets 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA