



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.		13586	418/55
2	Machined By		V.T.L. HLC Shop	Drg No. L-2-C/14924
3	Pallet Die No.		11354(4.0) HLC	Rev 2.00
4	Die Category	Drg. No.	Carbide	
5	Out Side Diameter	Drg. No.	630 HLC	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 HLC	
7	Width of Pellet Die	Drg. No.	222 HLC	
8	Grooves as per Drawing	Drg. No.	13x8x5 HLC / 13x8x5 HLC	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		HLC Shop	Tapping of holes 12 Bolt Side
12	Tapping PCD		565 HLC	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 HLC	Tapping Depth 18.8 HLC
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/12/24

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 HLC	Outside (3.3)		Inner				
3	External Relief Depth		15 HLC		7 HLC				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Forance
6	Material Sent For Hardening On Date			6	12	24			

Inspected By (Sign) & Date

Ravi 6/12/24

Saty 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA