



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		13520 ✓	30/50 ✓
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. 1.205-980
4	Die Category	Drg. No.	12599 (3.0) n/c	Rev 200 ✓
5	Out Side Diameter	Drg. No.	Extraxide	
6	Inside Diameter	Drg. No.	620 n/c, Step 0.02 Tapper 12°	
7	Width of Pellet Die	Drg. No.	520.12 n/c	Step length 18.5
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No of holes 12 Both Side
13	Tapping Hole Diameter		565 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c 2 Stack by n/c Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 20.4 n/c Tapping Depth = 18.6 n/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 11/12/24

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	13.5 n/c	Outside (3-3)		Inner				
3	External Relief Depth		23 n/c		20 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				11	12	24		

Inspected By (Sign) & Date

Ravi 11/12/24

Satish 12/12/24

Reviewed by (Engineer-CNC)

Manager-QA