



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.		13618	37/50
2	Machined By		V.T.L. H/O Shop	Drg No. L-20-9980
3	Pallet Die No.		13650 (3.5) H/O	Ravi
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	6.2 H/O Step OD = Tapper. 12°	
6	Inside Diameter	Drg. No.	5.2 H/O	Step length 18.5 H/O
7	Width of Pellet Die	Drg. No.	2.2 H/O	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/O / 13x8x5 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping No. of Holes 12 Both Side
12	Tapping PCD		56.5 H/O	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H/O Tapping Depth 18.5 H/O	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/12/24

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°
Ravi = 35

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0 H/O	Outside (3-3)	Inner			
3	External Relief Depth		2.0 H/O	1.3 H/O			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		19	12	24		

Inspected By (Sign) & Date

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA