



# 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.		14231	38/40
2	Machined By		V.T.L. H/O Shop	Drg No. 13315-062
3	Pallet Die No.		13315 (B.2) H/O	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/O, Step 00, 498.8 H/O	Tapken 12
6	Inside Diameter	Drg. No.	420.12 H/O	Step length 18 H/O
7	Width of Pellet Die	Drg. No.	158 H/O	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/O   12x8x3 H/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	
12	Tapping PCD		454 H/O	Tapping size of holes 8 Both Side
13	Tapping Hole Diameter		H202 Check by H20 B.12	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H/O	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/2/25

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

Counters 60

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	3.8 H/O	Outside (2.2)			Inner				
3	External Relief Depth		8 H/O			2 H/O				
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Formore
6	Material Sent For Hardening On Date		28	2	25					

Inspected By (Sign) & Date

Ravi 28/2/25

Sats 28/2/25

Reviewed by (Engineer-CNC)

Manager-QA