



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.		9865	31/50
2	Machined By		V.T.L. n/c Shop	Drg No. LSC-9980
3	Pallet Die No.		10625 (2.8)mm	Rev. 00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	6.20mm Step 0.02	Tapper = 12
6	Inside Diameter	Drg. No.	5.20mm	Step length = 18mm
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping Holes of 12mm Both Side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		12.0mm Check by 12.0 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4mm	Tapping Depth = 18.8mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/7/23

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

1	Counter Sinking Depth & Finish	OK							Rep = 40
2	External Relief Dia	3.1mm	outside (2-3)		Inner				
3	External Relief Depth		2.5mm		1.9mm				
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	7	23			

Inspected By (Sign) & Date

Ravi 11/7/23

Reviewed by (Engineer-CNC)

Manager-QA