



# 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

## Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10404	35/50
2	Machined By		V.T.L. n/c Shop	Drg No. 1-2-C-9980
3	Pallet Die No.		10811 (3.5)mm	Rev. 00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20mm Step OD, Tapper 12° Step length 18.5	
6	Inside Diameter	Drg. No.	5.20mm	
7	Width of Pellet Die	Drg. No.	2.22mm	
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 No. of Holes 12 Both side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		n/c, Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 2mm Tapping Depth 18.8mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 6/3/24

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

Counters 60°

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	U.O.H.H	Outside 3-31	Inner				
3	External Relief Depth		18mm	15mm				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Ramesh					
6	Material Sent For Hardening On Date		6	3	24			

Inspected By (Sign) & Date

Ravi 6/3/24

Reviewed by (Engineer-CNC)

Manager-QA