



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.		11581	45/50
2	Machined By		V.T.L. n/c Shop	Drg No. 13.9.406
3	Pallet Die No.		11987 (3.2) n/c	Rev. 00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	62mm, Step 00, 634mm	Tapping = 12
6	Inside Diameter	Drg. No.	52.14mm	Step length = 18mm
7	Width of Pellet Die	Drg. No.	222mm	Undercut = 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 No. of Holes = 12 Beta Side
12	Tapping PCD		565mm	
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 = 20.8mm	Tapping Depth = 18mm
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 29/3/24

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

1	Counter Sinking Depth & Finish	OK						Counter 2.6mm Rev 2 37
2	External Relief Dia	3.8mm	Outside (3-3)		Inner			
3	External Relief Depth		12mm		5mm			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark for name
6	Material Sent For Hardening On Date		29	3	24			
Inspected By (Sign) & Date		Raw: 29/3/24						

Reviewed by (Engineer-CNC)

Manager-QA