



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.		11996	36/42
2	Machined By		V.T.L. n/c Shop	Dry No. 1.3.0.968
3	Pallet Die No.		12117 (3-0) n/c	Rev 200
4	Die Category	Drg. No.	Ext. side	
5	Out Side Diameter	Drg. No.	604 n/c - Step 002 621.5 n/c	Tapper 12
6	Inside Diameter	Drg. No.	520.12 n/c	Step length 15
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut = 8.8 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
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		565 n/c	
13	Tapping Hole Diameter		420 - Check by 420 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.8 n/c	Tapping Depth: 19.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date *Ravi 11/5/24*

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 - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok						Counter = 60
2	External Relief Dia	3.3 n/c	All Rows					Row = 38
3	External Relief Depth		6 n/c					
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	5	24			

Inspected By (Sign) & Date *Ravi 11/5/24*

Reviewed by (Engineer-CNC) *Satish 11/5/24*

Manager-QA