



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.		11888	115/55
2	Machined By		V. T. L. N/A Shop	Drg. No. 1.3.2.407
3	Pallet Die No.		12153 (8.0) mm	Rev. 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	7.5 mm, 2d ep 0.2, 0.92-3mm	Tapping 12
6	Inside Diameter	Drg. No.	6.00-12 mm	Step length 2mm
7	Width of Pellet Die	Drg. No.	2.2-3mm	
8	Grooves as per Drawing	Drg. No.	12-8 x 7 mm / 12-8 x 7 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/A Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		64 mm	
13	Tapping Hole Diameter		M2 x 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 mm	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pass: 15/5/24

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

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

1	Counter Sinking Depth & Finish	OK					Counter 2.6°
2	External Relief Dia	8.5 mm	outside (3-3)	Inner			Rev 2 18
3	External Relief Depth		18 mm	10 mm			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		15	5	24		

Inspected By (Sign) & Date

Pass: 15/5/24

Reviewed by (Engineer-CNC)
Sats 15/5/24

Manager-QA