



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.			
2	Machined By		8887 to 10091	36/40
3	Pallet Die No.		V.T.L. H/c Shop	2195 Drg No. Lark 9810
4	Die Category	Drg. No.	8296 (2.8) H/H	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/H Step OD: 491 H/H	Step length: 12.4
7	Width of Pellet Die	Drg. No.	420.12 H/H	
8	Grooves as per Drawing	Drg. No.	158 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H/H 12x8x3 H/H	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping No. of Holes: 8 Both Side
13	Tapping Hole Diameter		454 H/H	
14	Tapping On Second Side	Half pitch of 1st side	H20 Check by H20 Bolt OK	
15	Tapping Hole Depth		Drill Depth: 18.4 H/H	Tapping Depth: 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/8/23

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 - 1 Hole Coloured

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

1	Counter Sinking Depth & Finish	OK							Ravi 26
2	External Relief Dia	3.3 H/H	Outside (2-2)		Inner				
3	External Relief Depth		10 H/H		4 H/H				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		8	8	23				

Inspected By (Sign) & Date

Ravi 31/8/23

Reviewed by (Engineer-CNC)

Manager-QA