



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.			
2	Machined By		10018	44/50
3	Pallet Die No.		V.T.L. H/c Shop	Dry No. Lark 8355 8310
4	Die Category	Drg. No.	10553 (3.5) H	
5	Out Side Diameter	Drg. No.	Extra wide	
6	Inside Diameter	Drg. No.	620.1 H Step OD 2 612 H Step length 19.5	
7	Width of Pellet Die	Drg. No.	520.12 H	
8	Grooves as per Drawing	Drg. No.	222 H	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H / 13x8x5 H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping No. of Holes: 12 Both Side
13	Tapping Hole Diameter		565 H	
14	Tapping On Second Side	Half pitch of 1st side	H20 y Check by H20 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth: 20.4 H Tapping Depth: 18.8	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi: 10/8/23

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

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.0 H	808 side (3-3)		Inner				Rov = 35
3	External Relief Depth		13 H		6 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			10	8	23			

Inspected By (Sign) & Date

Ravi: 10/8/23

Reviewed by (Engineer-CNC)

Manager-QA