



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.		12949	40/40
2	Machined By		Y. T. L. H/c Shop	Drg No. Lark 9310
3	Pallet Die No.		9895 (4.0) MM	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 MM Step 0.02 491 MM	Step length 17.5
6	Inside Diameter	Drg. No.	480.12 MM	
7	Width of Pellet Die	Drg. No.	158 MM	
8	Grooves as per Drawing	Drg. No.	12x8x3 MM / 12x8x3 MM	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No of Holes: 8 Both Side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 18.4 MM	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/9/24

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 60°
2	External Relief Dia	4.5 MM	Outside (2-2)	Inner			Radi = do
3	External Relief Depth		4 MM	Null			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		21	9	24		

Inspected By (Sign) & Date

Ravi 21/9/24

Reviewed by (Engineer-CNC)

Manager-QA