



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.		12998	32150
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 3310
3	Pallet Die No.		10521 (3.0) H/H	
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	620.1 H/H	Step 002 612 H/H
6	Inside Diameter	Drg. No.	520.12 H/H	Step length 19.5
7	Width of Pellet Die	Drg. No.	186.1 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H	13x8x5 H/H
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20 - Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 21.4 H/H	Tapping Depth: 19 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/9/24

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	9.5 H/H	Outside (3-3)	Inner				Low: 30
3	External Relief Depth		21 H/H	18 H/H				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							Lark Ravnare
6	Material Sent For Hardening On Date		23	9	24			

Inspected By (Sign) & Date

Ravi 23/9/24

Satya 23/9/24
Reviewed by (Engineer-CNC)

Manager-QA