



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.		13015 ✓	39/50/8752
2	Machined By		V. T. L. H/c Shop	Dy. No. Lark 3370
3	Pallet Die No.		11656 (3.5) H/H ✓	
4	Die Category	Drg. No.	33510	
5	Out Side Diameter	Drg. No.	62.2 H/H (A) Step 00.612 H/H	Step length = 9.4 ✓
6	Inside Diameter	Drg. No.	52.14 H/H (A)	
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 ✓	Tapping No. of Holes = 12 Both Side
13	Tapping Hole Diameter		H20 = Check by H20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21 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 = 65
2	External Relief Dia	4.0 H/H	Outside (3-3)	Inner				Ravi 23
3	External Relief Depth	✓	18 H/H	11 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		23	9	24			

Inspected By (Sign) & Date

Ravi 23/9/24

Setu 23/9/24

Reviewed by (Engineer-CNC)

Manager-QA