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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.		10045	
2	Machined By		V.T. G. M/c Shop	36/40
3	Pallet Die No.		10736 (3.5) M/m	Dy No. Lark SSTO
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.6 M/m	
6	Inside Diameter	Drg. No.	490.12 M/m	Step length 13.4
7	Width of Pellet Die	Drg. No.	158 M/m	
8	Grooves as per Drawing	Drg. No.	12x8x3 M/m	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		454 M/m	Tapping No. of holes 8 Both Side
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.6 M/m	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rasi 12/8/23

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	3.8 M/m	Outside (2-2)		Inner				
3	External Relief Depth		17 M/m		14 M/m				
4	Inspection Done Before Hardening By (Name)				Rasi				
5	Material Sent For Hardening By (Name)				Lark Fornare				
6	Material Sent For Hardening On Date		12	8	23				

Inspected By (Sign) & Date

Rasi 12/8/23

(Signature)
12/8/23

Reviewed by (Engineer-CNC)

Manager-QA