



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.		13028 ✓	45/50 ✓
2	Machined By		V.T.L. n/c Shop	Dy. Man Lark 355 3510 ✓
3	Pallet Die No.		13083 (3.5) n/c ✓	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	62 n/c ✓ Step 002 G12 n/c	Step length 19.4 ✓
6	Inside Diameter	Drg. No.	520.12 n/c ✓	
7	Width of Pellet Die	Drg. No.	222 n/c ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of Holes: 12 Both Side
12	Tapping PCD		565 n/c ✓	
13	Tapping Hole Diameter		M20 ✓ Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 n/c	Tapping Depth: 8.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/10/24

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

Counters 60

1	Counter Sinking Depth & Finish	OK							Counters 60 Ravi = 35
2	External Relief Dia	4.0 n/c ✓	Outside (23-3)		Inner				
3	External Relief Depth		12 n/c ✓		5 n/c ✓				
4	Inspection Done Before Hardening By (Name)				Ravi ✓				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		4	10	24				

Inspected By (Sign) & Date

Ravi 4/10/24

Reviewed by (Engineer-CNC)

Manager-QA