



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull 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.		INV ✓	40/50
2	Machined By		V.T.L n/c Shop	Dg No. Lark 3310
3	Pallet Die No.		13084(4.0)mm	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	62mm, Step OD = 61.2mm	Step length 19.5
6	Inside Diameter	Drg. No.	52.12mm	
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
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		56.5mm	
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 20.5mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/9/24

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	4.3mm	Outside (3.3)	Inner			Low = 31
3	External Relief Depth		14mm	10mm			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		19	9	24		

Inspected By (Sign) & Date

Ravi 19/9/24

20/9/24

Reviewed by (Engineer-CNC)

Manager-QA