



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.			
2	Machined By		13073 ✓	29/4 ✓ J15
3	Pallet Die No.		V.T.L. n/c Shop	Drg No. Lark 310
4	Die Category	Drg. No.	12442 (3.0) ✓	
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	499.7 mm. Step 002 491 mm	Step length 12.5 ✓
7	Width of Pellet Die	Drg. No.	420.12 mm ✓	
8	Grooves as per Drawing	Drg. No.	158 mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 mm / 12x8x3 mm ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 mm ✓	Tapping No. of Holes = 8 Both Side
13	Tapping Hole Diameter		M20 Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4 mm	Tapping Depth: 18.6 ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi: 29/10/24

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

1	Counter Sinking Depth & Finish	ok					Counter: 60°
2	External Relief Dia	3.5 mm	Outside (2-2)		Inner		Ravi: 29/10/24
3	External Relief Depth		14 mm		11 mm		
4	Inspection Done Before Hardening By (Name)						Ravi:
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date		29	10	24		

Inspected By (Sign) & Date

Ravi: 29/10/24

Reviewed by (Engineer-CNC)

Manager-QA