



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.		13194	40/50/6955
2	Machined By		V.T.L. HLC Shop	Dy. No. Lark 3310
3	Pallet Die No.		12825(5.0)H	
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	620H Step 00. 612H	Step length = 19.5
6	Inside Diameter	Drg. No.	520.12H	
7	Width of Pellet Die	Drg. No.	222H	
8	Grooves as per Drawing	Drg. No.	13x8x5H 13x8x5H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		HLC Shop	[Tapping No. of holes = 12 Back Side]
12	Tapping PCD		585H	
13	Tapping Hole Diameter		M20. Check by M20 B-11	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4H Tapping Depth 18.5H	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 24/10/24

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

Counter 60
Ravi 24

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	5.5H	outside (3-3)	Inner			
3	External Relief Depth		15H	10H			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		24	10	24		

Inspected By (Sign) & Date

Ravi 24/10/24

Satish 24/10/24

Reviewed by (Engineer-CNC)

Manager-QA