



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

8487

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.		13203	48/50 ✓
2	Machined By		V.T.L. H/A Shop	Dg No. Lark 3010
3	Pallet Die No.		13378 (3.5) H/A	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/A Step OD: 612 H/A	Step length 7.4 ✓
6	Inside Diameter	Drg. No.	520.12 H/A ✓	
7	Width of Pellet Die	Drg. No.	222 H/A ✓	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/A 13x8x5 H/A ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/A Shop	
12	Tapping PCD		565 H/A ✓	Tapping No. of holes = 12 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 = 20.4 H/A Tapping Depth = 18.6 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 6/11/24

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
Row = 31

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0 H/A	outside (3-3)		Inner		
3	External Relief Depth		15 H/A		8 H/A		
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Barrore				
6	Material Sent For Hardening On Date		6	11	24		

Inspected By (Sign) & Date

Ravi 6/11/24

Reviewed by (Engineer-CNC)

Manager-QA