



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13216 ✓	40/40 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. Lark 9870
3	Pallet Die No.		12691 (5.0) H/c ✓	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c ✓ Step OD 491 H/c	Step length 7.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 H/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 - 8 Both side
12	Tapping PCD		454 H/c ✓	
13	Tapping Hole Diameter		M20 - Check by new Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 18.3 H/c	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/11/24

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 17

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	5.5 H/c	Outside (2-2)		Inner		
3	External Relief Depth		4 H/c		Mill		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Parnore		
6	Material Sent For Hardening On Date		9	11	24		

Inspected By (Sign) & Date

Ravi 9/11/24

Signature

Reviewed by (Engineer-CNC)

Manager-QA