



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.		9594	36/60
2	Machined By		V.T.G n/c Shop	Drg No. 18.0.654
3	Pallet Die No.		10451 (8.0) n/c	Rev. No.
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	720 n/c Step 00. 692 n/c	Step length dr. 19.4
6	Inside Diameter	Drg. No.	600.12 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	36x1047 n/c / 36x1047 n/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, 12 Both Side
12	Tapping PCD		645 n/c	
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 n/c Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 9/6/23

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							Rev. 13
2	External Relief Dia	9.0 n/c	9.0 n/c	All Lines					
3	External Relief Depth			24 n/c					
4	Inspection Done Before Hardening By (Name)			Raw					
5	Material Sent For Hardening By (Name)			Lark Forware					
6	Material Sent For Hardening On Date			9 6 23					

Raw: 12/6/23

Inspected By (Sign) & Date

Raw: 9/6/23

Reviewed by (Engineer-CNC)

Manager-QA