



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.		13236	34/40
2	Machined By		V. T. C. NLC Shop	Dy. No. Lark 2870
3	Pallet Die No.		12693 (3.2) H4	
4	Die Category	Dr. No.	Senior	
5	Out Side Diameter	Dr. No.	500 H4 Step 00, 491 H4	Step length 17.4
6	Inside Diameter	Dr. No.	420.12 H4	
7	Width of Pellet Die	Dr. No.	158 H4	
8	Grooves as per Drawing	Dr. No.	12 x 8 x 3 H4 12 x 8 x 3 H4	
9	Fitting Sizes on CNC Plate	Dr. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		NLC Shop	Tapping No. of Holes = 8 Both Side
12	Tapping PCD		454 H4	
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 = 18.3 H4	Tapping Depth 16.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/11/24

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 - 1 Hole Closed (A)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK						Counter = 60° Row = 23
2	External Relief Dia	3.5 H4	Outside (2-2)		Inner			
3	External Relief Depth		10 H4		6 H4			
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		25	11	24			

Inspected By (Sign) & Date

Ravi 25/11/24

Satish 25/11/24

Reviewed by (Engineer-CNC)

Manager-QA