



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.		13412 ✓	
2	Machined By		V.T.L. n/c Shop	38/50/6355 Dy. H. Lark 3317
3	Pallet Die No.		13463(4.0) ✓	
4	Die Category	Drg. No.	Ext. outside ✓	
5	Out Side Diameter	Drg. No.	620mm, Step 02 = 612mm	Step length = 19.4
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm ✓	Tapping No. of 4.12.12 Both Side
13	Tapping Hole Diameter		M2x2 Check by M2x Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/11/24

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 Coloced (D)

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

Counter 60

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5mm	Outside (3-3)		Inner					
3	External Relief Depth		16mm		12mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date			30	11	24				

Inspected By (Sign) & Date

Ravi 30/11/24

Reviewed by (Engineer-CNC)

Manager-QA