



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.		13596	39/5/8852
2	Machined By		V.T.C. H/O Shop	Dy. Mgr. Lark 8852
3	Pallet Die No.		12439 (3.5) H/H	
4	Die Category	Drg. No.	88810	
5	Out Side Diameter	Drg. No.	6.20 H/H	Step length 19.5
6	Inside Diameter	Drg. No.	5.20.12 H/H	
7	Width of Pellet Die	Drg. No.	186 H/H	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/H / 13x8x5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping No. of holes 12 Both Side
12	Tapping PCD		565 H/H	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H/H	Tapping Depth 18.6 H/H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/12/24

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

1	Counter Sinking Depth & Finish	OK						Counter = 60°
2	External Relief Dia	4.0 H/H	Outside (3-3)		Inner			Low = 27
3	External Relief Depth		18 H/H		11 H/H			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		19	12	24			

Inspected By (Sign) & Date

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA