



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.		13614	38/50
2	Machined By		N.T.L. n/c Shop	Dry Holes Lark 8370
3	Pallet Die No.		12440(4.0)mm	
4	Die Category	Drg. No.	888-10	
5	Out Side Diameter	Drg. No.	620mm Step OD, 612mm	Step length 19.5mm
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	186mm	
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	Tapping Hole of Hole 12 Back Side
12	Tapping PCD		565mm	
13	Tapping Hole Diameter		n/c Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.6mm	
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 25
2	External Relief Dia	4.5mm	Outside (2-3)		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		19	12	24				

Inspected By (Sign) & Date

Ravi 19/12/24

Reviewed by (Engineer-CNC)

Manager-QA