



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.		13656	45/50, 6355
2	Machined By		V.T.L. N/C Shop	Dy. H. Lark 9370
3	Pallet Die No.		13667 (3-5) H4	
4	Die Category	Drg. No.	2 extraxide	
5	Out Side Diameter	Drg. No.	620 H4, Step OD = 612 H4	Step length 19.4
6	Inside Diameter	Drg. No.	520.14 H4	
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 H4	Tapping No. of Holes 12 Both Side
13	Tapping Hole Diameter		M20 = Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H4	Tapping Depth 18.6 H4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/12/24

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

Counter 600

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	4.0 H4	Outside (3-3)		Inner					
3	External Relief Depth		12 H4		5 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			20	12	24				

Inspected By (Sign) & Date

Ravi 20/12/24

Reviewed by (Engineer-CNC)

Manager-QA