



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.		13589	114/50
2	Machined By		V.T.L H/c Shop	255 Drg. No. Lark 330
3	Pallet Die No.		136710 (4.0) H/c	
4	Die Category	Drg. No.	Extruder die	
5	Out Side Diameter	Drg. No.	620.2 H/c, Step 0.0, G12 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	222.3 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes 12 Both side
12	Tapping PCD		56.5 H/c	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 H/c	Tapping Depth 18.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/11/24

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

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

Counter - 60
Lens - B1

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5 H/c	outside (3-3)		Inner		
3	External Relief Depth		14 H/c		6 H/c		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		21	12	24		

Inspected By (Sign) & Date

Ravi 21/11/24

Reviewed by (Engineer-CNC)
21/11/24

Manager-QA