



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.		13475 ✓	40/42
2	Machined By		V.T.L. H/C Shop	Dy. No. Lark 2175
3	Pallet Die No.		12359(4.0) H/H	✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/H, Step 002 491 H/H	Step length 17.5 H/H
6	Inside Diameter	Drg. No.	40.12 H/H	
7	Width of Pellet Die	Drg. No.	158 H/H ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/H 12x8x3 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/H	Tapping No. of Holes 8 Both side
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H/H	Tapping Depth 16.6 H/H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/12/24

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 = 60°

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	4.5 H/H	Outside (2-2)		Inner			
3	External Relief Depth		4 H/H		Null			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Lorraine			
6	Material Sent For Hardening On Date		23	12	24			

Inspected By (Sign) & Date

Ravi 23/12/24

Reviewed by (Engineer-CNC)

Manager-QA