



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)

8842

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13704 ✓	40/50
2	Machined By		V.T.L. n/c Shop	6355 Dy. M. Lark 8817
3	Pallet Die No.		13685 (B.2) ✓	
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	620mm ✓ Step 00, 612mm	Step length 19.5
6	Inside Diameter	Drg. No.	520.12mm ✓	
7	Width of Pellet Die	Drg. No.	222mm ✓	
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	
12	Tapping PCD		565mm ✓	[Tapping Dept of Holes = 12 Both Side]
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 20.2mm	Tapping Depth 18.60
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/12/24

1	As per programme no.		ok
2	Gun Drilling Work Completed On		ok
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	2.8mm	outside (3-3)		inner					
3	External Relief Depth		18mm		10mm					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Furnace					
6	Material Sent For Hardening On Date				25	12	24			

Inspected By (Sign) & Date

Ravi 25/12/24

Satyam 25/12/24

Reviewed by (Engineer-CNC)

Manager-QA