



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13652 ✓	33/40
2	Machined By		V.T.L N/C Shop	Drg No. Lark 3310
3	Pallet Die No.		13122 (3.0) ✓	
4	Die Category	Drg. No.	5210	
5	Out Side Diameter	Drg. No.	500 H4 ✓ Step OD: 491 H4	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H4 ✓	
7	Width of Pellet Die	Drg. No.	188 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4 12x8x3 H4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes: 8 Both Side
12	Tapping PCD		454 H4 ✓	
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 18.2 H4	Tapping Depth 18.6 H4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 24/12/24

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 - Hole Closed (P)

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

1	Counter Sinking Depth & Finish	OK						Counters 600 Per 230
2	External Relief Dia	3.5 H4	Outer Side (2-2)	Inner				
3	External Relief Depth		13 H4	7 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		24	12	24			

Inspected By (Sign) & Date

Ravi 24/12/24

Satya 24/12/24

Reviewed by (Engineer-CNC)

Manager-QA