



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.		9683	9683/40
2	Machined By		V.T.L. n/c Shop	Sign No. Lark 3510
3	Pallet Die No.		9149 (2.8) n/c	
4	Die Category	Drg. No.	590	
5	Out Side Diameter	Drg. No.	500 n/c Step OD = 491 n/c	Step length = 17.5
6	Inside Diameter	Drg. No.	480.1 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
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 n/c	
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 = 18.4 n/c	Tapping Depth = 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/6/23

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

1	Counter Sinking Depth & Finish	ok								Ravi 28/6/23
2	External Relief Dia	3.1 n/c	outside 2-25		Innen					
3	External Relief Depth		15 n/c		9 n/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		7		6		23			

Inspected By (Sign) & Date

Ravi 28/6/23

Reviewed by (Engineer-CNC)

Manager-QA