



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.		9755	40/50
2	Machined By		V.T.L. n/c Shop	Drg No. Lark 8810
3	Pallet Die No.		9945 (4.0) n/c	
4	Die Category	Drg. No.	Endsawide	
5	Out Side Diameter	Drg. No.	620 n/c Step OD: 612 n/c	Step length: 19.4
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	922 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 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: 12 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20x Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.4 n/c	Tapping Depth: 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 17/8/23	
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		Rev: 31
2	External Relief Dia	4.5 n/c	outside (3-3)	Inner
3	External Relief Depth	✓	14 n/c	10 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		17	6 23
Inspected By (Sign) & Date			Ravi 17/8/23	

Reviewed by (Engineer-CNC)

Manager-QA