



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.		10195 ✓	48/51
2	Machined By		V.T.L n/c Shop ✓	Drg No. 1.S.D. 380
3	Pallet Die No.		11004 (4.0) MH	Rev 2 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	800.7 MH →  →	Discussed with sales as per availability of Raw Material
6	Inside Diameter	Drg. No.	700.12 MH ✓	
7	Width of Pellet Die	Drg. No.	319.9 MH ✓	
8	Grooves as per Drawing	Drg. No.	25x10x9 MH 25x10x9 MH	
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		750 MH ✓	
13	Tapping Hole Diameter		M202 Check by M20 Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 35.4 MH	Tapping Depth 33.7
16	Perpendicularity of Tapped Hole		Yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date

Ravi 6/9/23

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 2 44
2	External Relief Dia	4.5 MH	outside (3-3)		Inner				
3	External Relief Depth	✓	11 MH		3 MH				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		6	9	23				

Inspected By (Sign) & Date

Ravi 6/9/23

Tawar Singh 6/9/23

Reviewed by (Engineer-CNC)

Manager-QA