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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.		14491	31/40%
2	Machined By		V. T. L. n/c Shop	Dry n/c Lark
3	Pallet Die No.		13747 (2.8) n/c	
4	Die Category	Drg. No.	5910	
5	Out Side Diameter	Drg. No.	500 n/c Step 00. 491 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 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 n/c 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 = 18.3 n/c	Tapping Depth = 166
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 19/3/25	
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		Counter, Ravi 31
2	External Relief Dia	3.3 n/c	Outside 22.25	Inner 9 n/c
3	External Relief Depth		15 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porace	
6	Material Sent For Hardening On Date		19 3 25	
Inspected By (Sign) & Date			Ravi 19/3/25	

Reviewed by (Engineer-CNC)

Manager-QA