

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)

9466

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14531	40/50 6355
2	Machined By		V.T.L. H/C Shop	Drg No. Lark 3310
3	Pallet Die No.		14470 (B.O) H/C	
4	Die Category	Drg. No.	Ende wide	
5	Out Side Diameter	Drg. No.	620 H/C Step 002 612 H/C	Step length 9.5
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of holes 12
12	Tapping PCD		565 H/C	Both Side
13	Tapping Hole Diameter		M202 Check by M20 B.H.	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 8.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/3/25	
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 60
2	External Relief Dia	3.3 H/C	Outside 22-3	Ravi 38
3	External Relief Depth		16 H/C	Inner 10 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		28 3 25	
Inspected By (Sign) & Date			Ravi 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA