

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

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14531	40/50
2	Machined By		V. T. L. H/C Shop	6355
3	Pallet Die No.		14471 (3.0) H	10
4	Die Category	Drg. No.	2 x 24 wide	
5	Out Side Diameter	Drg. No.	620 H, Step 0.0, 612 H	Step length 19.5
6	Inside Diameter	Drg. No.	520.12 H	
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H	13 x 8 x 5 H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		565 H	
13	Tapping Hole Diameter		M20.2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H	Tapping Depth 18.6
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 6.5
2	External Relief Dia	3.3 H	Outside (3-3)		Inner					Ravi 28/3/25
3	External Relief Depth		16 H		10 H					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrone
6	Material Sent For Hardening On Date		28	3	25					

Inspected By (Sign) & Date

Ravi 28/3/25

Reviewed By (Engineer-CNC)

Manager-QA