



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)

6050

S.No.	Check Parameter	Specification	Observations	Remarks
11	Work Order No.		10211	40/40
2	Machined By		V.T.L. N/C Shop	Dy. No. Lark 3510
3	Pallet Die No.		10337 (4.0) MM	
4	Die Category	Drg. No.	SEE	
5	Out Side Diameter	Drg. No.	500 MM Side OD 491 MM	Step length 12.5
6	Inside Diameter	Drg. No.	420.12 MM	
7	Width of Pellet Die	Drg. No.	182 MM	
8	Grooves as per Drawing	Drg. No.	12x8x3 MM / 12x8x3 MM	
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 8 Both Side
12	Tapping PCD		454 MM	
13	Tapping Hole Diameter		M202 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8 MM Tapping Depth 12.2 MM	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 11/9/23

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							Ravi 25
2	External Relief Dia	4.5 MM	Outside (2.2)		Inner				
3	External Relief Depth		4 MM		Mill				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			11	9	23			

Inspected By (Sign) & Date

Ravi 11/9/23

Reviewed by (Engineer-CNC)

Manager-QA