

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14727	33/40
2	Machined By		V. T. L. n/c Shop	Dyn. Lark
3	Pallet Die No.		14520 (3.0) n/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	499.8 n/c	Step length 14.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	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
12	Tapping PCD		454 n/c	of holes 8
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.4 n/c	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 13/4/25

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 n/c	outside (2.2)		Inner			Raw 224
3	External Relief Depth		13 n/c		7 n/c			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Porrace
6	Material Sent For Hardening On Date		13	4	25			

Inspected By (Sign) & Date

Raw: 13/4/25

Reviewed by (Engineer-CNC)

Manager-QA