

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.		14649	26/40/895
2	Machined By		V. T. L. n/c Shop	Dy. M. Lark 310
3	Pallet Die No.		14667 (3.0) m	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5mm n/c, Step 02: 490.8mm	Step length 275
6	Inside Diameter	Drg. No.	420.12mm (Box 419.8mm) ②	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
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 n/c Both Side
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		n/c Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.4mm	Tapping Depth: 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 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	3.3mm	Outside (2.25)	Inner 4mm
3	External Relief Depth		10mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		13 4 25	
Inspected By (Sign) & Date			Ravi Kumar 13/4/25	

Reviewed by (Engineer-CNC)

Manager-QA