



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)

9734

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14847	38/50/8/52
2	Machined By		V.T.L. H/c Shop	Dr. H. Lark 3310
3	Pallet Die No.		13134(4.0) H/c	
4	Die Category	Drg. No.	33310	
5	Out Side Diameter	Drg. No.	619.9 H/c, Step 002 611.9 H/c	Step length 19.5
6	Inside Diameter	Drg. No.	580.12 H/c	
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13-8-5 H/c 13-8-5 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	Bob side
13	Tapping Hole Diameter		H/c. Check by H/c Bell	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 26/4/25	
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	4.5 H/c	Outer Side 23-33	Inner 12 H/c
3	External Relief Depth		18 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 4 25	
Inspected By (Sign) & Date			Ravi 26/4/25	

Reviewed by (Engineer-CNC)

Manager-QA