



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10436	85/5-3832
2	Machined By		V.T.L. H/C Shop	Dy. Insp. Lark 3810
3	Pallet Die No.		10510 (2.5) mm	
4	Die Category	Drg. No.	33370	
5	Out Side Diameter	Drg. No.	62 mm / Step 00. 612 mm / Step length 19.5	
6	Inside Diameter	Drg. No.	52.12 mm	
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 mm / 13 x 8 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping dia of holes 12 Back Side
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		M20 = Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.4 mm	Tapping Depth 132
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 12/10/23

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 34
2	External Relief Dia	9.8 mm	90 side (3-3)		Inner				
3	External Relief Depth		9.8 mm		25 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Fortrace				
6	Material Sent For Hardening On Date		18	10	23				

Inspected By (Sign) & Date

Ravi 12/10/23

Reviewed by (Engineer-CNC)
Santosh 12/10/23

Manager-QA