



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		9768	34/40
2	Machined By		V.T.L. N/C Shop	Dry No. Lark 8810
3	Pallet Die No.		10365 (3.0) M4	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 M4 Step OD = 3.95 M4	Step length 14.5
6	Inside Diameter	Drg. No.	3.20 M4	
7	Width of Pellet Die	Drg. No.	141.8 M4	
8	Grooves as per Drawing	Drg. No.	15.4 x 7 x 2 M4 15.4 x 7 x 2 M4	
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		355 M4	
13	Tapping Hole Diameter		HIG. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.7 M4 Tapping Depth = 18.8 M4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/6/23	
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		Part 2
2	External Relief Dia	3.3 M4	Outside (2-2)	Inner
3	External Relief Depth		12 M4	6 M4
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		28	6 23
Inspected By (Sign) & Date			Ravi 28/6/23	

Re

Reviewed by (Engineer-CNC)

Manager-QA