



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.		10304 ✓	40/40 ✓
2	Machined By		V.T.L. n/c Shop	Dy. No. Lark 3570
3	Pallet Die No.		11199 (4.0) n/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4mm n/c, Step OD = 3.95 n/c	Step length 14.5
6	Inside Diameter	Drg. No.	3.20 n/c	
7	Width of Pellet Die	Drg. No.	14.8 n/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 n/c 15.5 x 7 x 2 n/c	
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 n/c	
13	Tapping Hole Diameter		MIG: Check by MIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 n/c Tapping Depth 19 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/11/23

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								Rap = 16
2	External Relief Dia	4.5 n/c	Outside (2-2)		Inner					
3	External Relief Depth		4 n/c		Nil					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Porrage					
6	Material Sent For Hardening On Date		3	11	23					

Inspected By (Sign) & Date

Ravi 31/11/23

Reviewed by (Engineer-CNC)

Manager-QA