



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.		10660	30/42/50 6355
2	Machined By		V.T.L. n/c Shop	Dy No 2 Lark SS10
3	Pallet Die No.		10819 (4.0) n/c	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 n/c, Step OD = 612 n/c / 613 n/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 n/c	
7	Width of Pellet Die	Drg. No.	222.1 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c / 13x8x5 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 = 12 Botu Side
12	Tapping PCD		565 n/c	
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 n/c	Tapping Depth = 18.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 8/11/23	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Row 31
2	External Relief Dia	4.5 n/c / 5.0 n/c	4.5 n/c All Lines	5.0 n/c All Lines
3	External Relief Depth		20 n/c	8 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porvace	
6	Material Sent For Hardening On Date		8	11
Inspected By (Sign) & Date			Ravi 8/11/23	

Reviewed by (Engineer-CNC)

Manager-QA