



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.		10676 ✓	210/40
2	Machined By		V.T.L. n/c Shop	Dy. M. Lark 395/310
3	Pallet Die No.		10712 (4.0) ✓	
4	Die Category	Drg. No.	Senior ✓	
5	Out Side Diameter	Drg. No.	500 H4 step 002-491 H4 ✓	Step length 17.5 H4 ✓
6	Inside Diameter	Drg. No.	420.12 H4 ✓	
7	Width of Pellet Die	Drg. No.	158 H4 ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 H4 / 12x8x3 H4 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK ✓	
10	Drilling Area Surface Smoothness		OK ✓	
11	Tapping Operator		n/c Shop	Tapping H4 of H.M.S. B Both Side
12	Tapping PCD		454 H4 / 453.9 H4	
13	Tapping Hole Diameter		M202 - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK ✓	
15	Tapping Hole Depth		Drill Depth = 19.8 H4 Tapping Depth = 17.4 H4 ✓	
16	Perpendicularity of Tapped Hole		yes ✓	
17	Visual Inspection Before Gun Drilling		OK ✓	

Inspected By (Sign) & Date

Ravi 15/11/23

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							Ravi 20
2	External Relief Dia	4.3 H4	Outside (2-2)		Inner				
3	External Relief Depth		4 H4		Nil				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			15	11	23			

Inspected By (Sign) & Date

Ravi 15/11/23

Reviewed by (Engineer-CNC)

Manager-QA