



Lark Engineering Co. (India)
 ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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.			
2	Machined By		10658 ✓ V. T. L. H/K Shop	40/40, 295 Dry No. Lark SS10
3	Pellet Die No.		10710 (5.0) H ✓	
4	Die category	Drg. No.	Senior	
5	Outside diameter	Drg. No.	499.7 H ✓ Step 002	490.7 H ✓ Step length 17.5
6	Inside Diameter	Drg. No.	490.12 H ✓	
7	Width Of Pellet Die	Drg. No.	158 H ✓	
8	Grooves As Per Drawing	Drg. No.	12x8x3 H ✓ / 12x8x3 H ✓	
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		454 H ✓	
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 18.5 H ✓	Tapping Depth 16.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 11/12/23	
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		Row = 17
2	External Relief Dia.	5.3 H ✓	Outer = 5.3 Inner = 4.2	
3	External Relief Depth		4 H ✓	
4	Inspection Done Before Hardening By (Name)		Ravi ✓	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11/12/23	
Inspected By (Sign) & Date			Ravi 11/12/23	

Sats ✓
 11/12/23
 Reviewed by (Engineer (CNC))

Manager-QA