



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	
2	Machined By		V.T.L. N/C Shop	34/40
3	Pallet Die No.		10366 (3.0) N/C	9109 10366 Lark 9810 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 N/C Step OD = 395 N/C	Step length = 14.5
6	Inside Diameter	Drg. No.	320.12 N/C	
7	Width of Pellet Die	Drg. No.	141 N/C (A)	
8	Grooves as per Drawing	Drg. No.	15.4 x 7 x 2 N/C / 15.2 x 7 x 2 N/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok (B)	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		355 N/C	Tapping No of holes = 8 Both Side
13	Tapping Hole Diameter		MIG Check by MIG Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.7 N/C Tapping Depth = 18.8	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/7/23

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							
2	External Relief Dia	3.3 N/C	outside (2-2)		inner				Ravi 20
3	External Relief Depth		1.2 N/C		3 N/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date			3	7	23			

Inspected By (Sign) & Date

Ravi 31/7/23

Reviewed by (Engineer-CNC)

Manager-QA