



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.		10579	33/50
2	Machined By		V.T.L. n/c Shop	Drg No. Lark 8752
3	Pallet Die No.		10514 (3.0) n/c	8870
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	6.20 n/c, Step OD = 6.12 n/c	Step length: 19.5
6	Inside Diameter	Drg. No.	5.20.12 n/c	
7	Width of Pellet Die	Drg. No.	1.86 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 Both Side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M2, Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.6 n/c	Tapping Depth: 8.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/1/23

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								Rep = 30
2	External Relief Dia	3.5 n/c	outside (3-3)		Inner					
3	External Relief Depth	/	2.3 n/c		1.7 n/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Porrace
6	Material Sent For Hardening On Date									11 23

Inspected By (Sign) & Date

Ravi 11/1/23

Reviewed by (Engineer-CNC)

Manager-QA