



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.		10578	36/49
2	Machined By		V.T.L H/C Shop	Dy. Mgr Lark 3819
3	Pallet Die No.		11515 (4.0) H/C	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/C Step 002 395 H/C	Step length 14.5
6	Inside Diameter	Drg. No.	320.12 H/C	
7	Width of Pellet Die	Drg. No.	142 H/C	
8	Grooves as per Drawing	Drg. No.	15.5x7x2 H/C / 15.5x7x2 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		355 H/C / 354.9 H/C	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 H/C Tapping Depth 19.2 H/C	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/12/23

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 - 1 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK							Rep-16
2	External Relief Dia	4.3 H/C	Outside (2-2)		Inner				
3	External Relief Depth		8 H/C		4 H/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		14	12	23				

Inspected By (Sign) & Date

Ravi 14/12/23

Reviewed by (Engineer-CNC)

Manager-QA