



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)

66.30

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10901	40/40
2	Machined By		V.T.L N/C Shop	2195 Dy. Mgr. Lark 8310
3	Pallet Die No.		10732 (4.0) H4	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H4 Step OD 2 491 H4	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H4	
7	Width of Pellet Die	Drg. No.	158 H4	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H4 / 12 x 8 x 3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping dia of holes 8 Both side
12	Tapping PCD		454 H4	
13	Tapping Hole Diameter		M2 x 2 Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.4 H4 Tapping Depth 17.5 H4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/12/23

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							Ravi 20
2	External Relief Dia	4.5 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 Pomece				
6	Material Sent For Hardening On Date		18	12	23				

Inspected By (Sign) & Date

Ravi 18/12/23

Reviewed by (Engineer-CNC)

Manager-QA