



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.		10909	30/50
2	Machined By		V. T.L. M/C Shop	3355 Dy. No. Lark 3310
3	Pallet Die No.		11254 (Q.0) H4	
4	Die Category	Drg. No.	Ext. inside	
5	Out Side Diameter	Drg. No.	620 H4 Step CD = 612 H4	Step length = 19.5
6	Inside Diameter	Drg. No.	520.14 H4	
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565 H4	
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 = 21 H4 Tapping Depth = 19 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 31/7/24

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 Counter = 60

1	Counter Sinking Depth & Finish	ok							low = 38
2	External Relief Dia	3.5 H4	outside (2-3)		Inner				
3	External Relief Depth		2.3 H4		20 H4				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date			8	1	23			

Inspected By (Sign) & Date Ravi 31/7/24

Reviewed by (Engineer-CNC) Sohy 31/07/24

Manager-QA