



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

6835

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		11160 ✓	40/50/655
3	Pallet Die No.		V.T.I. n/c Shop	Drg No. Lark 9810
4	Die Category	Drg. No.	11456 (3.5) n/c	
5	Out Side Diameter	Drg. No.	2nd side	
6	Inside Diameter	Drg. No.	620 n/c, 3rd side 612 n/c	Step length 17.4
7	Width of Pellet Die	Drg. No.	520.12 n/c	
8	Grooves as per Drawing	Drg. No.	222 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	Tapping No. of holes = 12 Back side
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 n/c	Tapping Depth = 18.8 n/c
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 25/1/24

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 - 1 Hole Closed (A)

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

Counter = 60

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 n/c	outside (3-3)		Inner				
3	External Relief Depth		15 n/c		8 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Formace				
6	Material Sent For Hardening On Date		25	1	24				

Inspected By (Sign) & Date

Ravi 25/1/24

Reviewed by (Engineer-CNC)

Manager-QA