



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Rev. No.

01

6862

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.			
2	Machined By		10959	32/40
3	Pallet Die No.		V.T.L. H/c Shop	Drg. No. Lark 3319
4	Die Category	Drg. No.	11502 (3.5) H/c	
5	Out Side Diameter	Drg. No.	Junior	
6	Inside Diameter	Drg. No.	400 H/c, Step 00, 395 H/c	Step length: 14 H/c
7	Width of Pellet Die	Drg. No.	320.12 H/c	
8	Grooves as per Drawing	Drg. No.	142 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	15.5x7x2 H/c / 15.5x7x2 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	Tapping H/c of Holes = 8 Batu Side
13	Tapping Hole Diameter		355 H/c	
14	Tapping On Second Side	Half pitch of 1st side	HIG = Check by HIG Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 21.8 H/c Tapping Depth = 19 H/c	
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Ravi 29/1/24

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

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

Counter = 60 Row = 18

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.0 H/c	outside (2-2)		Inner		
3	External Relief Depth		12 H/c		8 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		29	1	24		

Inspected By (Sign) & Date

Ravi 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA