



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.			
2	Machined By		11241	35/40
3	Pallet Die No.		V.T.L. H/C Shop	8119 Drg No. Lark 3330
4	Die Category	Drg. No.	10987 (3.5) H	
5	Out Side Diameter	Drg. No.	500 H	
6	Inside Diameter	Drg. No.	Step 00 = 491 H	Step length = 17.5
7	Width of Pellet Die	Drg. No.	420.12 H	
8	Grooves as per Drawing	Drg. No.	182 H	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3 H / 12x8x3 H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/C Shop	Tapping No of Holes = 8 Both Side
13	Tapping Hole Diameter		454 H / 453.9 H	
14	Tapping On Second Side	Half pitch of 1st side	H2 = Check by H2 Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.8 H Tapping Depth = 17 H	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 5/8/24

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

1	Counter Sinking Depth & Finish	ok						Counter = 60° Relief = 27°
2	External Relief Dia	4.0 H	outside (2.2)	Inner				
3	External Relief Depth		8 H	5 H				
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		5	2	24			

Inspected By (Sign) & Date

Ravi 5/8/24

Reviewed by (Engineer-CNC)

Manager-QA