



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.		11259	32/40
2	Machined By		V.T.L. n/c Shop	3195
3	Pallet Die No.		10954 (L10) n/c	Drg No. Lark 3370
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	50mm n/c	
6	Inside Diameter	Drg. No.	Step OD = 49mm n/c	Step length = 17.4
7	Width of Pellet Die	Drg. No.	480.12mm	
8	Grooves as per Drawing	Drg. No.	158mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3mm / 12x8x3mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		n/c Shop	Tapping No of holes = 8 Both Side
13	Tapping Hole Diameter		454mm / 453.9mm	
14	Tapping On Second Side	Half pitch of 1st side	M20 = Check by M20 Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 19.7mm	Tapping Depth = 17mm
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Ravi 5/2/24

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°
2	External Relief Dia	4.5mm	outside (2-2)		Inner		Ross do
3	External Relief Depth		12mm		8mm		
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 5/2/24

Sohal 6/2/24

Reviewed by (Engineer-CNC)

Manager-QA