



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11292 ✓	38/55
2	Machined By		V.T.L. n/a Shop	Dy. No. L.S.O. 407
3	Pallet Die No.		11635 (4.0) n/a	Reo = 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710 n/a	Step 02 = 698.8 n/a
6	Inside Diameter	Drg. No.	600.12 n/a	Step length = 20 n/a
7	Width of Pellet Die	Drg. No.	222 n/a	
8	Grooves as per Drawing	Drg. No.	12+8+7 n/a / 12+8+7 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping Hd of holes = 12 Both Side
12	Tapping PCD		640 n/a	
13	Tapping Hole Diameter		M20 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Repdn. 21.4 n/a	Tapping Depth = 8.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 13/8/24

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	
2	External Relief Dia	4.5 n/a	Outside 23-31	Inner			Reo = 31	
3	External Relief Depth		21 n/a	17 n/a				
4	Inspection Done Before Hardening By (Name)						Ravi	
5	Material Sent For Hardening By (Name)						Lark Porcelain	
6	Material Sent For Hardening On Date		13	8	24			
Inspected By (Sign) & Date			Ravi 13/8/24					

Reviewed by (Engineer-CNC)

Manager-QA