



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

6857

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11164	35/40
2	Machined By		V.T.L H/c Shop	3199 Dry H/c Lark 3310
3	Pallet Die No.		10981 (3-5) H/c	
4	Die Category	Drg. No.	9210	
5	Out Side Diameter	Drg. No.	500 H/c Step 00, 491 H/c	Step length 12.4
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 2 Bolt Side
12	Tapping PCD		454 H/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 19.5 H/c Tapping Depth 17 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/1/24

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 600

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.0 H/c	outside 2-2.5		inner					
3	External Relief Depth		8 H/c		5 H/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		28	1	24					

Inspected By (Sign) & Date

Ravi 28/1/24

Saty 29/1/24

Reviewed by (Engineer-CNC)

Manager-QA