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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.		10522	31/50/655
2	Machined By		V. T. L. N/C Shop	Drg. No. Lark 8510
3	Pallet Die No.		10835 (3.5) H4	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H4, Step OD = 618 H4 / 613 H4	
6	Inside Diameter	Drg. No.	520.14 H4 (A)	Step length. 19.4
7	Width of Pellet Die	Drg. No.	222 H4	
8	Grooves as per Drawing	Drg. No.	13x8x5 H4 / 13x8x5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	Tapping No. of holes - 12 Both Side
12	Tapping PCD		565 H4	
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. 20.7 H4 Tapping Depth. 18.7	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date Ravi 19/3/24

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 2.65	
2	External Relief Dia	4.0 H4	Outside (3-3)	Inner			
3	External Relief Depth		22 H4	19 H4			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Forace				
6	Material Sent For Hardening On Date		19	3	24		

Inspected By (Sign) & Date Ravi 19/3/24

Saty 19/3/24

Reviewed by (Engineer-CNC)

Manager-QA