



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.		11547	34/50
2	Machined By		V. T. L. n/c Shop	Drg No. Lark 8452
3	Pallet Die No.		11401 (3-2) n/c	SS17
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	620mm Step OD = 612mm	Step length 19.4
6	Inside Diameter	Drg. No.	520.12mm	
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Crilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		565mm	Tapping No. of holes = 12 Both Side
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 = 20.8mm Tapping Depth = 18.8mm	
16	Perpendicularity of Tapped Hole		Med	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/3/24

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 - 2 hole closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok							Counter Sink
2	External Relief Dia	4.3mm	Outside (3-3)		Inner				Low - de
3	External Relief Depth		19mm		18mm				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		23	3	24				

Inspected By (Sign) & Date

Ravi 23/3/24

Reviewed by (Engineer-CNC)
23/3/24

Manager-QA