



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.		11580	40/40, 91109
2	Machined By		V.T.L. H/c Shop	Dy. In-charge Lark 8370
3	Pallet Die No.		11586 (5.0) H/c	
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 H/c	Step 00. 395 H/c
6	Inside Diameter	Drg. No.	320.12 H/c	Step length 14.5
7	Width of Pellet Die	Drg. No.	142 H/c	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 H/c	15.5 x 7 x 2 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes & Rate Side
12	Tapping PCD		355 H/c	
13	Tapping Hole Diameter		MIG 2 Check by MIG Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 21 H/c	Tapping Depth 18.8 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date: Ravi 4/4/24

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° Ravi = 14
2	External Relief Dia	5.5 H/c	outside (2.2)	Inner				
3	External Relief Depth		5 H/c	Mill				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		4	4	24			

Inspected By (Sign) & Date: Ravi 4/4/24

Reviewed by (Engineer-CNC): Sats 4/4/24

Manager-QA