



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.		11898	31150
2	Machined By		V.T.L. H/C Shop	Dry H/C, Lark 8510
3	Pallet Die No.		# 13114 (3.5) H/C	
4	Die Category	Drg. No.	External	
5	Out Side Diameter	Drg. No.	6.20 H/C, Step 002 6.12 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	5.907 H/C	
7	Width of Pellet Die	Drg. No.	9.9 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C 13x8x5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping of holes on both side
12	Tapping PCD		56.5 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 20.8 H/C	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 9/5/24

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 = 60

1	Counter Sinking Depth & Finish	OK								Ravi 35
2	External Relief Dia	4.0 H/C	Outside (3-3)		Inner					
3	External Relief Depth		9.9 H/C		19 H/C					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		9	5	24					

Inspected By (Sign) & Date

Ravi 9/5/24

Satyam 9/5/24

Reviewed by (Engineer-CNC)

Manager-QA