



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.		11915	44/50
2	Machined By		V. T. L. M/C Shop	Dy. H. S. Lark 8870
3	Pallet Die No.		11652 (4.0) 44	Res. 2000
4	Die Category	Drg. No.	58870	
5	Out Side Diameter	Drg. No.	6.20 44 Step 00. 812 44	Step length 19.5
6	Inside Diameter	Drg. No.	5.20.12 44	
7	Width of Pellet Die	Drg. No.	1.86 44	
8	Grooves as per Drawing	Drg. No.	13.48 x 5 44 13.48 x 5 44	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	Tapping of holes 12 Rota Side
12	Tapping PCD		5.65 44	
13	Tapping Hole Diameter		M2.2 Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 44	
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 18.8
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 10/5/24

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

1	Counter Sinking Depth & Finish	ok						Counter. G. Rove 25
2	External Relief Dia	4.5 44	outside (23-3)		Inner			
3	External Relief Depth		14 44		6 44			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date			10	5	24		

Inspected By (Sign) & Date

Ravi 10/5/24

Reviewed by (Engineer-CNC)

Manager-QA