



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

7500

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.			
2	Machined By		11986 ✓	118/50 6355
3	Pallet Die No.		V.T.L. n/a Shop	Day No. Lark 8810
4	Die Category	Drg. No.	11986 (3.5) n/a	
5	Out Side Diameter	Drg. No.	External	
6	Inside Diameter	Drg. No.	6.20 n/a Step 0.612 n/a	Step length 19.5
7	Width of Pellet Die	Drg. No.	5.20.12 n/a	
8	Grooves as per Drawing	Drg. No.	3.3.3 n/a ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/a / 13x8x5 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping No. of holes 12
12	Tapping PCD		565 n/a	Both Side
13	Tapping Hole Diameter		M20, Check by M20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.8 n/a	Tapping Depth 18.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sooi 15/5/24

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						Count 235
2	External Relief Dia	4.0 n/a	Outside (3-2)		Inner			
3	External Relief Depth		15 n/a		8 n/a			
4	Inspection Done Before Hardening By (Name)				Rad			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date			15	5	24		

Inspected By (Sign) & Date

Sooi 15/5/24

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Reviewed by (Engineer-CNC)

Manager-QA