



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.		11955	36/50
2	Machined By		V.T.L. H/c Shop	655 Dugale Lark 3810
3	Pallet Die No.		12124 (3.0) H/c	
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	6.2mm Step OD = 6.12mm	Step length = 9.5
6	Inside Diameter	Drg. No.	5.20-12 H/c	
7	Width of Pellet Die	Drg. No.	3.2 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		n/c Shop	
12	Tapping PCD		585 H/c	Tapping dia of holes = 12 Rate side
13	Tapping Hole Diameter		H20, Check by H20 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 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 16/5/24

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 - 3 Hole Closed (3)

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	3.5 H/c	Outside (3-3)	Inner			Ravi 38
3	External Relief Depth		20 H/c	14 H/c			
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Porrace
6	Material Sent For Hardening On Date		16	5	24		

Inspected By (Sign) & Date

Ravi 16/5/24

Sats 16/5/24

Reviewed by (Engineer-CNC)

Manager-QA