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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		147419	37150
2	Machined By		V. T. L. H/C Shop	8255
3	Pallet Die No.		14630 (3.5) H/C	By No. Lark 8310
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	619.9 H/C, Step 00. 3119 H/C	Step length 19.5
6	Inside Diameter	Drg. No.	520.14 H/C	
7	Width of Pellet Die	Drg. No.	222 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	
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H22 Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 15/4/25

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

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1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.0 H/C	Outside (3-3)		Inner				
3	External Relief Depth		17 H/C		13 H/C				
4	Inspection Done Before Hardening By (Name)				Sasi				
5	Material Sent For Hardening By (Name)				Lark Porrace				
6	Material Sent For Hardening On Date		15	9	25				

Inspected By (Sign) & Date

Sasi 15/4/25

Reviewed by (Engineer-CNC)

Manager-QA