



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)

9019

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14060	36/50
2	Machined By		V.T.L H/C Shop	Digital 1.2.09980
3	Pallet Die No.		13682 (4.0) H/C	Rev 2.00
4	Die Category	Drg. No.	Ext. outside	
5	Out Side Diameter	Drg. No.	620 H/C	Step 002 Tapper 12°
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 18.5
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	Tapping H/C of holes 12 Boh 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 = 20.2 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/1/25

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 - 1 Hole. Closed (A)	

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 30

1	Counter Sinking Depth & Finish	ok								
2	External Relief Dia	4.5 H/C	outside (3-3)		inner					
3	External Relief Depth		18 H/C		14 H/C					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		17	1	25					

Inspected By (Sign) & Date

Ravi 17/1/25

Satyam 17/1/25

Reviewed by (Engineer-CNC)

Manager-QA