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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

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14378	39/52
2	Machined By		V. T. C. H/c Shop	Qty 10, 18.0-549
3	Pallet Die No.		14126 (B.0) H/c	Rev 200
4	Die Category	Drg. No.	H. T. 1000	
5	Out Side Diameter	Drg. No.	704 H/c, Step 002, 693 H/c	Step length 20 H/c
6	Inside Diameter	Drg. No.	600.12 H/c	Tapper 12°
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12x10x7.5 H/c / 12x10x7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of holes 12
12	Tapping PCD		640 H/c	Both Side
13	Tapping Hole Diameter		H222 Check by H22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c Tapping Depth 18.6 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Savi 19/3/25	
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				
1	Counter Sinking Depth & Finish	OK		Counter 38
2	External Relief Dia	3.5 H/c	Outside (B-3)	Inner
3	External Relief Depth		19 H/c	13 H/c
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		19 3 25	
Inspected By (Sign) & Date			Savi 19/3/25	

Savi 19/3/25

Reviewed by (Engineer-CNC)

Manager-QA