

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.		14408 ✓	33/50 ✓
2	Machined By		V.T.L. H/c Shop	Dr H. 18.0.998
3	Pallet Die No.		13729 (3.0) H/c	Rev. 00
4	Die Category	Drg. No.	Outside	
5	Out Side Diameter	Drg. No.	6.20 H/c	Step on. Tapper 12°
6	Inside Diameter	Drg. No.	5.20.12 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	2.22 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		5.65 H/c	
13	Tapping Hole Diameter		H/c 2 Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Savi 22/3/25	
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	
2	External Relief Dia		2.3 H/c	Outside 2.3-2.5
3	External Relief Depth		2.3 H/c	Inner 1.7 H/c
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Ferrance	
6	Material Sent For Hardening On Date		22	3 25
Inspected By (Sign) & Date			Savi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA