

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.		14425	40/40/200
2	Machined By		V. T. L. H/c Shop	1 Day later last 310
3	Pallet Die No.		13572 (4.0) H/c	
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	500 H/c, Step 002 491 H/c	Step 0.25
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 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 8
12	Tapping PCD		454 H/c	Both Side
13	Tapping Hole Diameter		M20, Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H/c	Tapping Depth 16
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 13/3/25	
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 25	
2	External Relief Dia	4.5 H/c	Outside 22-25	Inner Mill
3	External Relief Depth		4 H/c	Mill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		13	3 25
Inspected By (Sign) & Date			Ravi 13/3/25	

Reviewed by (Engineer-CNC)

Manager-QA