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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.		14410	40/55
2	Machined By		V.T.L. H/c Shop	Drg. No. 18.2.557
3	Pallet Die No.		13604 (R.O) H/c	Reo 200
4	Die Category	Drg. No.	SSS TO	
5	Out Side Diameter	Drg. No.	630 H/c / Step 00 - 624 H/c	Step length down
6	Inside Diameter	Drg. No.	520.12 H/c	Tapper 12
7	Width of Pellet Die	Drg. No.	18.2 H/c	
8	Grooves as per Drawing	Drg. No.	12-10x5 H/c / 12-10x5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c of holes 12
12	Tapping PCD		565 H/c	Bottom Side
13	Tapping Hole Diameter		M16 - Check by M16 B-1	
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			Rao! 20/3/25	
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 Sink 214
2	External Relief Dia	8.5 H/c	Outside (3-3)	Inner
3	External Relief Depth		23 H/c	15 H/c
4	Inspection Done Before Hardening By (Name)		Rao!	
5	Material Sent For Hardening By (Name)		Lark for race	
6	Material Sent For Hardening On Date		20 3 25	
Inspected By (Sign) & Date			Rao! 20/3/25	

Reviewed by (Engineer-CNC)

Manager-QA