

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.			
2	Machined By		14450	36/47
3	Pallet Die No.		V.T.L. n/c Shop	1 Dry Holes 1.5.0.1275
4	Die Category	Drg. No.	14302 (3.0) n/c	Rev. 1.00
5	Out Side Diameter	Drg. No.	Extrawide	2
6	Inside Diameter	Drg. No.	614 n/c Step 002 622.2 n/c	Tabber 20
7	Width of Pellet Die	Drg. No.	520.12 n/c	Step length 1.8 n/c
8	Grooves as per Drawing	Drg. No.	222 n/c	Under cut 4.1 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c / 13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping Holes 12
12	Tapping PCD		565 n/c	Bottom Side
13	Tapping Hole Diameter		H20. Check by H20 Rule	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.2 n/c	Tapping Depth 8.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 24/3/25

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

Counter 60

1	Counter Sinking Depth & Finish	ok								Sasi 38
2	External Relief Dia	3.5 n/c	outside 23-35		Inner					
3	External Relief Depth		17 n/c		11 n/c					
4	Inspection Done Before Hardening By (Name)									Sasi
5	Material Sent For Hardening By (Name)									Lark Porroce
6	Material Sent For Hardening On Date		24	3	25					

Inspected By (Sign) & Date

Sasi 24/3/25

Reviewed by (Engineer-CNC)

Manager-QA