

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)

9499

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14421	36/44/50
3	Pallet Die No.		V.T.C. H/C Shop	1. Dy. H. 1.2.21/85
4	Die Category	Drg. No.	12018 (3.0) H/C	Rev. 02
5	Out Side Diameter	Drg. No.	H/C	
6	Inside Diameter	Drg. No.	70mm Step 001 Tapper 12°	
7	Width of Pellet Die	Drg. No.	80mm 1.2 H/C	Step length 17.1
8	Grooves as per Drawing	Drg. No.	265 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x7 H/C 15x8x7 H/C	Face side step
10	Drilling Area Surface Smoothness		OK	0.8mm Deep Both Side
11	Tapping Operator		H/C Shop	Tapping of holes 16
12	Tapping PCD		640mm	Both Side
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 2/4/25	
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 Go
2	External Relief Dia	3.5mm/4.0mm	3.5mm All Rows = 14mm	Row = 43
3	External Relief Depth		4.0mm All Rows = 6mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Ravi 2/4/25	

Reviewed by (Engineer-CNC)

Manager-QA