

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9475

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14272	45/50
2	Machined By		V.T.L. n/c Shop	Qty No. 1-8.0-18
3	Pallet Die No.		13187(3.0) n/c	Rev. 02
4	Die Category	Drg. No.	820	
5	Out Side Diameter	Drg. No.	520 n/c Step 002 491 n/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 n/c	
7	Width of Pellet Die	Drg. No.	182 n/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	
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 18.2 n/c Tapping Depth 18.0	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Sasi 29/3/25

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 60
2	External Relief Dia	3.5 n/c	Outside (2-2)		Inner					Low 30
3	External Relief Depth		11 n/c		5 n/c					
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date		29	3	25					

Inspected By (Sign) & Date

Sasi 29/3/25

Reviewed by (Engineer-CNC)

Manager-QA