

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

9474

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14272	45/50
2	Machined By		V.T.L. H/C Shop	Dr H- 120/18
3	Pallet Die No.		1318.8 (3.0) H/C	Rev 02
4	Die Category	Drg. No.	SEP	
5	Out Side Diameter	Drg. No.	520 H/C	Step 00 - 491 H/C
6	Inside Diameter	Drg. No.	420.12 H/C	Step length 17.5
7	Width of Pellet Die	Drg. No.	182 H/C	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 H/C	12.8 x 3 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		H20, Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 H/C	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 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		
2	External Relief Dia	3.5 H/C	Outside (2.2)	Inner
3	External Relief Depth		11 H/C	5 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ravi	
6	Material Sent For Hardening On Date		29 3 25	
Inspected By (Sign) & Date			Ravi 29/3/25	

Reviewed by (Engineer-CNC)

Manager-QA