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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14565	52/52
2	Machined By		V. T. L. H/C Shop	Dr. H. L. S. 933
3	Pallet Die No.		14719 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	388-10	
5	Out Side Diameter	Drg. No.	624 H/C	Step 60.613 H/C
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 19.5
7	Width of Pellet Die	Drg. No.	186 H/C	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 3 H/C	13 x 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		565 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 20.2 H/C	Tapping Depth 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 3/4/25	
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		
2	External Relief Dia	4.5 H/C	Outside (3-3)	Inner
3	External Relief Depth		5 H/C	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		3 4 25	
Inspected By (Sign) & Date			Ravi 3/4/25	

Reviewed by (Engineer-CNC)

Manager-QA