

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)

9460

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14534	40/40/8/15
2	Machined By		V. T. L. H/c Shop	1. Dg No. 100010
3	Pallet Die No.		13990 (5.0) H/c	
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c, Step OD = 491 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 H/c / 12 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	Tapping No. of Holes 8
12	Tapping PCD		454 H/c	Both Side
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 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/3/25

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 Bo
2	External Relief Dia	5.5 H/c	Outside (2.2)		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 Porvace			
6	Material Sent For Hardening On Date		28	3	25			

Inspected By (Sign) & Date

Ravi 28/3/25

Reviewed by (Engineer-CNC)

Manager-QA