

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)

9500

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14521	36/44/50
2	Machined By		V. T. C. H/c Shop	Drg No. 68014805
3	Pallet Die No.		13882 (3.0) H/c	Rev 208
4	Die Category	Drg. No.	H/c	
5	Out Side Diameter	Drg. No.	701 H/c, Step 00, Tappet 12	
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 71
7	Width of Pellet Die	Drg. No.	265 H/c	
8	Grooves as per Drawing	Drg. No.	15x8x7 H/c 15x8x7 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		640 H/c	
13	Tapping Hole Diameter		H/c, Check by H20 Ball	Tapping H/c of Holes = 16 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 H/c	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 21/4/25	
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 60°
2	External Relief Dia	3.5 H/c 4.0 H/c	3.5 H/c All Rows 2 14 H/c	Row 2 43
3	External Relief Depth	4.0 H/c	All Rows 2 6 H/c	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Sasi 21/4/25	

Reviewed by (Engineer-CNC)

Manager-QA