

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)

9473

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14476	45/55
2	Machined By		V.T.C. H/C Shop	Drg. H. (12.0.512)
3	Pallet Die No.		14434 (3.8) H/C	Rev 2.00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	530 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.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H. of holes & Bottom side
12	Tapping PCD		454 H/C	
13	Tapping Hole Diameter		03/4" - Check by 03/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.2 H/C	Tapping Depth 18.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Savi 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 Bo. 21
2	External Relief Dia	4.3 H/C	Outside 22.25	Inner 10 H/C
3	External Relief Depth		17 H/C	
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Porace	
6	Material Sent For Hardening On Date		29 3 25	
Inspected By (Sign) & Date			Savi 29/3/25	

Reviewed by (Engineer-CNC)

Manager-QA