

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)

95031

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14559	28/40/45
2	Machined By		V.T.L. H/C Shop	Drill Holes 18.2mm
3	Pallet Die No.		12862(4.0)mm	Rev: 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	510mm	Step 00: 490 8mm Step length 174
6	Inside Diameter	Drg. No.	420-12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	[Tapping Holes 2 Both Side]
12	Tapping PCD		456mm	
13	Tapping Hole Diameter		H202 Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.2mm Tapping Depth: 18.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 2/4/25

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

Counter 20

1	Counter Sinking Depth & Finish	ok						Raw: 20
2	External Relief Dia	4.5mm / 5.0mm	4.5mm	All Rows	2 17mm			
3	External Relief Depth		5.0mm	All Rows	2 5mm			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date							2 4 25

Inspected By (Sign) & Date

Raw: 2/4/25

Reviewed by (Engineer-CNC)

Manager-QA