

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.		14657	50/50
2	Machined By		V. T. L. H/c Shop	Dry Holes 1st & 2nd 9980
3	Pallet Die No.		14485 (6.0) H/c	Recess
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	620 H/c, Step 00	Tapping 12°
6	Inside Diameter	Drg. No.	520.12 H/c	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c 13x8x5 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 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Revi 7/4/25

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 = 60
Row = 23

Note : Mark the defective holes/Missed holes with the help of Permanent Marker									
1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	6.5 mm	Outside (3-3)		Inner				
3	External Relief Depth		6mm		Nil				
4	Inspection Done Before Hardening By (Name)				Law!				
5	Material Sent For Hardening By (Name)				Lank Burner				
6	Material Sent For Hardening On Date			2	4	25			

Inspected By (Sign) & Date

Var: 24/25

Reviewed by (Engineer-CNC)

Manager-QA