

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)

9660

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14668 ✓	36/55 ✓
2	Machined By		V. T. C. H/O Shop	Drill 12.0.453
3	Pallet Die No.		14998(3.0) ✓	Rev. 00
4	Die Category	Drg. No.	J210	
5	Out Side Diameter	Drg. No.	740 ✓ Step 00.743.444	Tapped 10.0
6	Inside Diameter	Drg. No.	630.12 ✓	Step length. 23.1
7	Width of Pellet Die	Drg. No.	290 ✓	Width cut. 1.8 ✓
8	Grooves as per Drawing	Drg. No.	1548x5 ✓ 1548x5 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/O Shop	Tapping H. of holes 12
12	Tapping PCD		685 ✓	Both Side
13	Tapping Hole Diameter		H200 Check by H200 ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.444	Tapping Depth. 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 19/4/25	
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 - 2 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter. 60 Rows 48
2	External Relief Dia	2.5 ✓	Outside (3.5)	Inner 19 ✓
3	External Relief Depth		25 ✓	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Romance	
6	Material Sent For Hardening On Date		19 4 25	
Inspected By (Sign) & Date			Ravi 19/4/25	