

9578



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.		14688 ✓	45/55
2	Machined By		V.T.C. H/c Shop	Drg No. 12.0-453
3	Pallet Die No.		14999 (4.5) ✓	Rev. 2.00
4	Die Category	Drg. No.	Yes ✓	
5	Out Side Diameter	Drg. No.	740 H/c, Step 0.0-743.5 H/c	Tapper 10°
6	Inside Diameter	Drg. No.	620.12 H/c	Step length 23 H/c
7	Width of Pellet Die	Drg. No.	290 H/c	Under cut 1.75 H/c
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c 15x8x5 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/c
12	Tapping PCD		685 H/c	of holes 16
13	Tapping Hole Diameter		H2.2 Check by H2.2 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 10/4/25

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 - Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 2 Bo

1	Counter Sinking Depth & Finish	OK						Raw: 38
2	External Relief Dia	5.0 H/c	Outside (3-3)		Inner			
3	External Relief Depth		15 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		10	4	25			

Inspected By (Sign) & Date

Raw: 10/4/25

Reviewed by (Engineer-CNC)

Manager-QA