

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasoull Road, Yamuna Nagar - 135 001 (Haryana)

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9566

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14773	45/50
2	Machined By		V.T.L. M/C Shop	Dr H. 1.20.993
3	Pallet Die No.		14464 (5.0) M/C	Rev. 100
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20 M/C	Step 00. Tapper 12°
6	Inside Diameter	Drg. No.	5.20.14 M/C	Step length 18.5
7	Width of Pellet Die	Drg. No.	2.22 M/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 M/C	13x8x5 M/C
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		56.5 M/C	
13	Tapping Hole Diameter		M/C - Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 M/C	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 9/4/25	
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				
1	Counter Sinking Depth & Finish	OK		Count error
2	External Relief Dia	5.3 M/C	outside (3-3)	Row 226
3	External Relief Depth		10 M/C	5 M/C
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		9	4
Inspected By (Sign) & Date			Sasi 9/4/25	

Reviewed by (Engineer-CNC)

Manager-QA