

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

Sl. No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14516	33/50/
2	Machined By		V.T.L. n/c Shop	6955
3	Pallet Die No.		14469 (3.0) n/c	6950
4	Die Category	Drg. No.	Extra side	
5	Out Side Diameter	Drg. No.	620 n/c, Step 611.9 n/c	Step length 19.5
6	Inside Diameter	Drg. No.	526.14 n/c	
7	Width of Pellet Die	Drg. No.	222 n/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c 13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping Holes of holes 12 Both Side]
12	Tapping PCD		565 n/c	
13	Tapping Hole Diameter		n/c 20 - Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 13/4/25	
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		Counter - Ravi
2	External Relief Dia	3.5 n/c	Outside 23-35	Inner 17 n/c
3	External Relief Depth		23 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		13 4 25	
Inspected By (Sign) & Date			Ravi 13/4/25	

Reviewed by (Engineer-CNC)

Manager-QA