

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.		14696	36/50
2	Machined By		V. T. C. H/c Shop	Dr. H. 1.25.125-1
3	Pallet Die No.		14412 (3.8) H/c	Rev. 01
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c, Step 02, 693 H/c	Tapping 12
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 20 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12-8x7 H/c 12-8x7 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 of holes = 12
12	Tapping PCD		640 H/c	Both Side
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 20/4/25	
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 60
2	External Relief Dia	4.3 H/c	Outside (2.3-3.5)	Inner
3	External Relief Depth		18 H/c	14 H/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		20	4
Inspected By (Sign) & Date			Ravi 20/4/25	