

Lark Engineering Company (India) Pvt. Ltd.

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

9659

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.			
2	Machined By		14741	40/40
3	Pallet Die No.		V.T.L. M/C Shop	1 Dg H. 1.20
4	Die Category	Drg. No.	14681(4.0) M/C	Recess
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 M/C Step 02, 498.8	Tapping 12
7	Width of Pellet Die	Drg. No.	420.12 M/C	Step length 134
8	Grooves as per Drawing	Drg. No.	158 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 M/C 12 x 8 x 3 M/C	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	
13	Tapping Hole Diameter		454 M/C	
14	Tapping On Second Side	Half pitch of 1st side	420.2 Check by 420.3 M/C	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 18.4 M/C	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		Yes	
			OK	

Inspected By (Sign) & Date

Raw: 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

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

1	Counter Sinking Depth & Finish	OK						Counter Sink
2	External Relief Dia	4.5 M/C	Outside 2.25		Inner			
3	External Relief Depth		4 M/C		Will			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		19	4	25			

Inspected By (Sign) & Date

Raw: 19/4/25

Reviewed by (Engineer-CNC)

Manager-QA