

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)

9741

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14807	40/55
2	Machined By		V. T. L. H/C Shop	Drilling No. 1.20.14751
3	Pallet Die No.		13597 (8.0) H/C	Rev. 1.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	629.9 H/C, Step 00 = 621.5 H/C	Tapper 12
6	Inside Diameter	Drg. No.	520.12 H/C	Step length 21.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13 x 8 x 5 H/C 13 x 8 x 5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping No. of Holes 12
12	Tapping PCD		56.5 H/C	Both Side
13	Tapping Hole Diameter		M20: Check by H2 Bolt	
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 28/4/25	
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	8.5 H/C	20 Side (23-3)	Inner
3	External Relief Depth		23 H/C	15 H/C
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Parnace	
6	Material Sent For Hardening On Date		28/4/25	
Inspected By (Sign) & Date			Ravi 28/4/25	

Reviewed by (Engineer-CNC)

Manager-QA