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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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14769	35/40
2	Machined By		V.T.L. H/c Shop	Dry Hole 12.02 782
3	Pallet Die No.		13764 (3.5) H/c	Reo 00
4	Die Category	Drg. No.	SEN	
5	Out Side Diameter	Drg. No.	500 H/c Step 002 491 H/c	Step length 4 H/c
6	Inside Diameter	Drg. No.	420.12 H/c	
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	10x10x5 H/c 10x10x8 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		455 H/c	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" Ball	Tapping H/c of Holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.4 H/c	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 30/4/25	
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 es. 00 Rep. 28
2	External Relief Dia	4.0 H/c	Outside 2.25	Inner
3	External Relief Depth		8 H/c	5 H/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		30 4 25	
Inspected By (Sign) & Date			Ravi 30/4/25	

Reviewed by (Engineer-CNC)

Manager-QA