

Lark Engineering Company (India) Pvt. Ltd.

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

Inprocess Inspection (Pellet Dies)

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

9781

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14767	36/45
2	Machined By		V. T. L. w/c Shop	Drg No. 1-2-0-952
3	Pallet Die No.		14363(3.0) w/c	Rev. 00
4	Die Category	Drg. No.	Tonier	
5	Out Side Diameter	Drg. No.	394.8 w/c, Step 002 382.8 w/c	Step length 12
6	Inside Diameter	Drg. No.	305.12 w/c	
7	Width of Pellet Die	Drg. No.	100 w/c	
8	Grooves as per Drawing	Drg. No.	10 x 7 x 4 w/c 10 x 7 x 4 w/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		w/c Shop	Tapping No. of Holes 8
12	Tapping PCD		349 w/c	Both Side
13	Tapping Hole Diameter		M12 2 Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 w/c	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Raw: 31/5/25	
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 - 1 Hole Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok	Counter 14	
2	External Relief Dia	3.5 w/c	Outside (2.2)	Inner
3	External Relief Depth	15 w/c	9 w/c	
4	Inspection Done Before Hardening By (Name)		Raw:	
5	Material Sent For Hardening By (Name)		Lark Kurnace	
6	Material Sent For Hardening On Date		3	5 25
Inspected By (Sign) & Date			Raw: 31/5/25	