



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.			
2	Machined By		15032	45/50/655
3	Pallet Die No.		V.T.L. H/c Shop	Day no. Lark
4	Die Category	Drg. No.	14631 (3.5) H/c	
5	Out Side Diameter	Drg. No.	2220 wide	
6	Inside Diameter	Drg. No.	620 H/c Step OD 611.9 H/c	Step length 19.5
7	Width of Pellet Die	Drg. No.	520.14 H/c	
8	Grooves as per Drawing	Drg. No.	221.9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 H/c 13x8x5 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		565 H/c	
14	Tapping On Second Side	Half pitch of 1st side	N200 Check by H2 Bolt	Tapping H. of hole 12 Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 H/c	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Res: 20/5/25

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

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

1	Counter Sinking Depth & Finish	ok							Counter 26
2	External Relief Dia	4.0 H/c	Outside 3-3		Inner				Res: 35
3	External Relief Depth		12 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)								Res:
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		20	5	25				

Inspected By (Sign) & Date

Res: 20/5/25

Reviewed by (Engineer-CNC)

Manager-QA