

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)

9904

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14961	30/5/25
3	Pallet Die No.		N-7.1 n/c Shop	Drilling 12.2, 11.4
4	Die Category	Drg. No.	14723 (H.O) n/c	Rev. m/c
5	Out Side Diameter	Drg. No.	58870	
6	Inside Diameter	Drg. No.	620 n/c, Step on 623 n/c	Tapping 12"
7	Width of Pellet Die	Drg. No.	520.14 n/c	Step length 2.1 n/c
8	Grooves as per Drawing	Drg. No.	186 n/c	Under cut 1.5 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x3 n/c, 13x8x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		585 n/c	
13	Tapping Hole Diameter		n/c Check by H2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 n/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 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, 25
2	External Relief Dia	4.5 n/c	Outside (2-3)	Inner
3	External Relief Depth		22 n/c	18 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Permare	
6	Material Sent For Hardening On Date		20	5
Inspected By (Sign) & Date			Ravi 20/5/25	

Reviewed by (Engineer-CNC)

Manager-QA