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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14885	25/50
2	Machined By		V. T. L. W/O. Shop	Qty 4. 1.23998
3	Pallet Die No.		14844 (3.0) W/O	Removal
4	Die Category	Drg. No.	Extrusion	
5	Out Side Diameter	Drg. No.	619.9 W/O Step on	Tabber 12
6	Inside Diameter	Drg. No.	520.14 W/O	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 W/O	
8	Grooves as per Drawing	Drg. No.	13x8x5 W/O 13x8x5 W/O	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		W/O Shop	
12	Tapping PCD		565 W/O	
13	Tapping Hole Diameter		W/O Check by H.O.B.	Tapping H. of 4.12398
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 20.4 W/O	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Y.R.S	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rev: 25/5/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		W/O	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 8
2	External Relief Dia	3.5 W/O	Outside (3-3)	Inner
3	External Relief Depth		21 W/O	15 W/O
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Removal	
6	Material Sent For Hardening On Date		23 5 25	
Inspected By (Sign) & Date			Ravi 23/5/25	

Reviewed by (Engineer-CNC)

Manager-QA