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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.		14924	55/66
2	Machined By		V. T. L. H/c Shop	Dr. H. 18.2.92
3	Pallet Die No.		15149 (8.0) H/c	Revised
4	Die Category	Drg. No.	M. Y. M. H/c	
5	Out Side Diameter	Drg. No.	680.1 H/c	Step 00. 698 H/c
6	Inside Diameter	Drg. No.	546.12 H/c	(Box. 548.2 H/c) Step long H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut. 2.8
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c	32 x 7 x 9.1 H/c (4 x 8) 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		619 H/c	
13	Tapping Hole Diameter		M16. Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 33.5 H/c	Tapping Depth. 31.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			S. S. 28/5/25	
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		
2	External Relief Dia	9.0 H/c	All Rows	
3	External Relief Depth		11 H/c	
4	Inspection Done Before Hardening By (Name)		Rev.	
5	Material Sent For Hardening By (Name)		Lark P. M. H/c	
6	Material Sent For Hardening On Date		28	5 25
Inspected By (Sign) & Date			S. S. 28/5/25	

Counter Sinking By
Rev. 18

S. S. 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA