



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		15100	30/40
3	Pallet Die No.		V.T.L. H/c Shop	Drill 12.0.81
4	Die Category		15077 (B-2) H/c	Rev. 01
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	500 H/c, Step 002 499 H/c	Tappet - 12"
7	Width of Pellet Die	Drg. No.	420/4 H/c	Step length 12 H/c
8	Grooves as per Drawing	Drg. No.	158 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 x 3 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	
13	Tapping Hole Diameter		454 H/c	Tapping H/c of Holes 8
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 19 H/c Tapping Depth 17 H/c	
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

Raw: 2/6/25

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						Counters B/c
2	External Relief Dia	13.5 H/c	Outside (2-2)		Inner			Raw: 25
3	External Relief Depth		13 H/c		10 H/c			
4	Inspection Done Before Hardening By (Name)							Raw:
5	Material Sent For Hardening By (Name)							Lark Permare
6	Material Sent For Hardening On Date			2	6	25		

Inspected By (Sign) & Date

Raw: 2/6/25

Reviewed by (Engineer-CNC)

Manager-QA