

10/100

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

CNC/QA/FM/

Rev. No.

01

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15101	410/60
2	Machined By		V. T. L. H/C Shop	Dr. H. 12.0.7
3	Pallet Die No.		14916 (8.0) H/C	Rev. 00
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	720 H/C Step OP. 692-84	Tapping 12
6	Inside Diameter	Drg. No.	600.14 H/C	Step length 20
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	127107 7.5 H/C / 127107 7.5 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H/C of holes 12
12	Tapping PCD		640 H/C	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/C Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 5/6/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		None	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter 30°
2	External Relief Dia	8.5 H/C	Outside 23-35	Inner 20 H/C
3	External Relief Depth		25 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark For name	
6	Material Sent For Hardening On Date		5/6/25	
Inspected By (Sign) & Date			Ravi 5/6/25	

Reviewed by (Engineer-CNC)

Manager-QA