



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		15182	53/55
3	Pallet Die No.		V.T.L. H/C Shop	Qty 4, 1-2-2, 280
4	Die Category	Drg. No.	14384 (3.8) H	Rev. 10
5	Out Side Diameter	Drg. No.	529.9 H	
6	Inside Diameter	Drg. No.	Step 002 490.9 H	Step length 7 H
7	Width of Pellet Die	Drg. No.	420.14 H	
8	Grooves as per Drawing	Drg. No.	182 H	
9	Fitting Sizes on CNC Plate	Drg. No.	10x10x5 H / 10x10x5 H	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		455 H	
13	Tapping Hole Diameter		03/4" 2 Check by 03/4" B	Tapping H. of holes = 8 Body Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.4 H	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

1-6/25

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							
2	External Relief Dia	4.3 H	outside 72-25		Inner				
3	External Relief Depth		9 H		2 H				
4	Inspection Done Before Hardening By (Name)				Rasi				
5	Material Sent For Hardening By (Name)				Lark Ransare				
6	Material Sent For Hardening On Date		10	6	25				

Inspected By (Sign) & Date

1-6/25

Reviewed by (Engineer-CNC)

Manager-QA