

10/02

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.		15304 ✓	42/50 ✓
2	Machined By		V. T. L. H/C Shop	Qty H. 1.80.998
3	Pallet Die No.		14803(4.0) H/C	Rev. 00
4	Die Category	Drg. No.	2x2x2 side	
5	Out Side Diameter	Drg. No.	620 H/C, Step 00. Tapp. 12°	
6	Inside Diameter	Drg. No.	520.14 H/C	Step length 18.5
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/C / 13x8x5 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. of Holes. 12 Both Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 20.4 H/C	Tapping Depth. 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 18/6/25

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							Counter: 60
2	External Relief Dia	4.5 H/C	90° Side (3-3)		Inner				Row: 31
3	External Relief Depth		11 H/C		7 H/C				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Purnace				
6	Material Sent For Hardening On Date			18	6	25			

Inspected By (Sign) & Date

Ravi: 18/6/25

Reviewed by (Engineer-CNC)

Manager-QA