



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		15251	60/65
3	Pallet Die No.		V.T.L. H/c Shop	Dy. H. 12.02.14
4	Die Category	Drg. No.	15312(3.5) H/c	Renzo
5	Out Side Diameter	Drg. No.	790 H/c	
6	Inside Diameter	Drg. No.	Step 002 792 H/c	Step length 26.5
7	Width of Pellet Die	Drg. No.	660.14 H/c	1200 center 1 H/c
8	Grooves as per Drawing	Drg. No.	324 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 H/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		725 H/c	Tapping H/c of H. 12.02.14
13	Tapping Hole Diameter		H202 Check by H20 B.12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.5 H/c	Tapping Depth 29.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

1	As per programme no.			2 31.02
2	Gun Drilling Work Completed On			32.1 H/c
3	Hole Finish In Gun Drilling	Marked		8 H/c
4	Defective Holes (If Any)		ok	Both Side

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	4.0 H/c	Outside (3-3)		Inner			Renzo 51
3	External Relief Depth		12 H/c		5 H/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		24	6	25			

Inspected By (Sign) & Date

Renzo 24/6/25

Reviewed by (Engineer-CNC)

Manager-QA