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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.		15243 ✓	55/70
2	Machined By		V.T.L. H/c Shop	Qty 120 681
3	Pallet Die No.		14054(8.0) H/c	Reverse
4	Die Category	Drg. No.	70mm	
5	Out Side Diameter	Drg. No.	840 H/c Step 00-800 H/c	Set length
6	Inside Diameter	Drg. No.	700.14 H/c	
7	Width of Pellet Die	Drg. No.	370 H/c	
8	Grooves as per Drawing	Drg. No.	25x10x9 H/c / 25x10.5x9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10	Drilling Area Surface Smoothness		OK	0.0 H/c Drill
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		750 H/c	of 14.12.12
13	Tapping Hole Diameter		H202 Check by H22 B.H.	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 235.4 H/c	Tapping Depth 33
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 4/7/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK							Ravi 30
2	External Relief Dia	8.5 H/c	Outside 25.35		Inner				
3	External Relief Depth		24 H/c		15 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		4	7	25				

Inspected By (Sign) & Date

Ravi 4/7/25

Reviewed by (Engineer-CNC)

Manager-QA