

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.		15354	42/50
2	Machined By		V. T. L. n/c Shop	Qty No. 1.2.0 496
3	Pallet Die No.		14419 (4.0) n/c	Reor 20
4	Die Category	Drg. No.	M. 70 n/c	
5	Out Side Diameter	Drg. No.	700 n/c	Step 00. 692.8 n/c
6	Inside Diameter	Drg. No.	600.14 n/c	Tapken. 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length. 80 n/c
8	Grooves as per Drawing	Drg. No.	12x10x7.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x10x7.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	
13	Tapping Hole Diameter		640 n/c	
14	Tapping On Second Side	Half pitch of 1st side	n/c 2 Check by n/c Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.4 n/c	Tapping Depth 18.5
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Res: 21/7/25

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 - 2 hole Colused

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 n/c	Outside (3-3)		Inner			Row. 31
3	External Relief Depth		12 n/c		8 n/c			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Res: 21/7/25

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Reviewed by (Engineer-CNC)

Manager-QA