

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)

10871

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16075 to 16309	50/50
2	Machined By		V. T. L. H/C Shop	Qty 1000
3	Pallet Die No.		15897 (B.O) H/C	Reve 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	519.9 H/C	Step on 490.9 H/C
6	Inside Diameter	Drg. No.	420.14 H/C	Step length 13.5
7	Width of Pellet Die	Drg. No.	158 H/C	
8	Grooves as per Drawing	Drg. No.	12.8 x 3 H/C / 12.8 x 3 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/C of holes 8
12	Tapping PCD		454 H/C	Both Side
13	Tapping Hole Diameter		H2.2 Check by H2.2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.5 H/C	Tapping Depth 16.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 14/10/25	
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	8.5 H/C	Outside 2.25	Inside
3	External Relief Depth		4 H/C	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purnack	
6	Material Sent For Hardening On Date		14 10 25	
Inspected By (Sign) & Date			Ravi 14/10/25	

Manager-QA

Reviewed by (Engineer-CNC)