



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		11921 ✓	53/55
3	Pallet Die No.		✓-T.I. n/c Shop	Dr. Has (3.9. 512)
4	Die Category	Drg. No.	11887 (3.8) ✓ Senior	Rev: ✓
5	Out Side Diameter	Drg. No.	53044 ✓	
6	Inside Diameter	Drg. No.	42012 ✓	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 ✓	
8	Grooves as per Drawing	Drg. No.	12+8+3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	12+8+3 ✓	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 ✓	Tapping of holes on Back side
13	Tapping Hole Diameter		ok	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19.8 ✓	Tapping Depth 17.2
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/5/24

- As per programme no.
- Gun Drilling Work Completed On
- Hole Finish In Gun Drilling
- Defective Holes (If Any)

Marked

ok

No

Note : Mark the defective holes/missed holes with the help of Permanent Marker

Counter for Part

1	Counter Sinking Depth & Finish	ok						
2	External Relief Dia	4.344	Outside (2.2)	Inner				
3	External Relief Depth		9.44	2.44				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		18	5	24			

Inspected By (Sign) & Date

Ravi 18/5/24

Satyam 18/5/24

Reviewed by (Engineer-CNC)

Manager-QA