



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.		14397	32/40
2	Machined By		V.T.L. M/c Shop	Drill. 1.8.0.7.400
3	Pallet Die No.		13571 (2.8) M/c	Rev 2.01
4	Die Category	Drg. No.	500	
5	Out Side Diameter	Drg. No.	500 M/c Step 00. 491.8 M/c	Step length 17 M/c
6	Inside Diameter	Drg. No.	420.12 M/c	
7	Width of Pellet Die	Drg. No.	182 M/c	
8	Grooves as per Drawing	Drg. No.	10x9.5x5 M/c / 10x9.5x5 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping M/c of M/c. B Both Side
12	Tapping PCD		457 M/c	
13	Tapping Hole Diameter		M20. Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 M/c Tapping Depth 18.6 M/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 17/3/25	
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. 60-31
2	External Relief Dia	3.3 M/c	outside (2.2)	Inner
3	External Relief Depth		13 M/c	8 M/c
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		17 3 25	
Inspected By (Sign) & Date			Sasi 17/3/25	

F.

Reviewed by (Engineer-CNC)

Manager-QA