



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)

9881

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14930/	40/45
2	Machined By		V.T.L. H/c Shop	Drill H. (2.0.904
3	Pallet Die No.		14967 (3.2) H/c	Rev. 00
4	Die Category	Drg. No.	580	
5	Out Side Diameter	Drg. No.	510 H/c Step OD 498.88	Tapping H. 12
6	Inside Diameter	Drg. No.	420.12 H/c	Step length 18
7	Width of Pellet Die	Drg. No.	189 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c / 12x8x3 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. of Hole 8
12	Tapping PCD		454 H/c	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 19 H/c Tapping Depth 17 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Inspected By: 16/5/25

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	3.8 H/c	Outside (2-2)		Inner				Rev. 28
3	External Relief Depth		1 H/c		5 H/c				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		16	5	25				

Inspected By (Sign) & Date

Inspected By: 16/5/25

Reviewed by (Engineer-CNC)

Manager-QA