

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

10854

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			
3	Pallet Die No.		16147	38/45
4	Die Category		V.T.L. H/C Shop	Dy No. 1-3-42
5	Out Side Diameter	Drg. No.	16057 (5.0) H/C	Rev. 02
6	Inside Diameter	Drg. No.	382	
7	Width of Pellet Die	Drg. No.	509.9 H/C, Step 02. 490.9 H/C	
8	Grooves as per Drawing	Drg. No.	420.14 H/C	Step length 12.5
9	Fitting Sizes on CNC Plate	Drg. No.	182 H/C	
10	Drilling Area Surface Smoothness	Drg. No.	12x8x3 H/C / 12x8x3 H/C	
11	Tapping Operator		OK	
12	Tapping PCD		H/C Shop	
13	Tapping Hole Diameter		454 H/C	Tapping H/C of holes 8
14	Tapping On Second Side	Half pitch of 1st side	H20 = Check by H20 Ball	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 18.4 H/C	Tapping Depth 18.4
17	Visual Inspection Before Gun Drilling		Yes	

Inspected By (Sign) & Date

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		OK	

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

1	Counter Sinking Depth & Finish	OK								Counter 26
2	External Relief Dia	5.5 H/C	Outside (2-2)							Rev. 2
3	External Relief Depth		18 H/C							
4	Inspection Done Before Hardening By (Name)									Raoi
5	Material Sent For Hardening By (Name)									Lark Engineering
6	Material Sent For Hardening On Date		13	10	25					

Inspected By (Sign) & Date

13/10/25
Reviewed by (Engineer-CNC)

Manager-QA