

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.		14279	55/87
2	Machined By		N. T. C. N/A Shop	Drill Hole 1.2.0.2.117
3	Pallet Die No.		14498(8.0)mm	Rev: 02
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	680mm, Step 00 693.2mm	Tabber 5"
6	Inside Diameter	Drg. No.	546.1mm	Step length 3mm
7	Width of Pellet Die	Drg. No.	178mm	12dmm = 4.75mm
8	Grooves as per Drawing	Drg. No.	3047x8mm / 3047x8mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/A Shop	
12	Tapping PCD		614mm	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Tap	Tabbing Hole of Holes - 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30mm	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/4/25	One Drill Hole
1	As per programme no.			Size 0.25mm
2	Gun Drilling Work Completed On			Depth 2.24mm
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				Count on 3.9
1	Counter Sinking Depth & Finish	ok		Row 9
2	External Relief Dia	9.0mm	111 Rows	
3	External Relief Depth		12mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Ravi 21/4/25	

Reviewed by (Engineer-CNC)

Manager-QA