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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	55/67
2	Machined By		V.T.L. H/c Shop	Drill No. 18.02.117
3	Pallet Die No.		14499 (8.0) H/c	Rev. 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	68 mm, Step 02, 698.2 mm	Tapped 5"
6	Inside Diameter	Drg. No.	546.1 mm	Step length 30 mm
7	Width of Pellet Die	Drg. No.	178 mm	Under cut 4.8
8	Grooves as per Drawing	Drg. No.	30 x 7 x 8 mm 30 x 7 x 8 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 8
12	Tapping PCD		614 mm	Both Side
13	Tapping Hole Diameter		11/2" = Check by 11/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 30.2 mm 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 035 mm
2	Gun Drilling Work Completed On			Depth 224 mm
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				
1	Counter Sinking Depth & Finish	ok		Counter 23
2	External Relief Dia	9.0 mm	All Rows	
3	External Relief Depth		12 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Ravi 21/4/25	

Reviewed by (Engineer-CNC)

Manager-QA