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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.		14383	35/60/90
2	Machined By		V.T.L. H/C Shop	Drilling 12.02359
3	Pallet Die No.		12960 (6.0)	Revised
4	Die Category	Drg. No.	MJEK	
5	Out Side Diameter	Drg. No.	752mm Step on 777mm/776mm/875mm	
6	Inside Diameter	Drg. No.	572.12mm	Step length 40mm 24.5mm
7	Width of Pellet Die	Drg. No.	270mm	
8	Grooves as per Drawing	Drg. No.	106x8x12mm / 88x8x12mm	Under cut 12.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping Hole of Hole 6
12	Tapping PCD		660mm	
13	Tapping Hole Diameter		23/4" = Check by 23/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and Third Side One Side	
15	Tapping Hole Depth		Drill Depth 35.2mm Tapping Depth 33.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 21/3/25	1 Side
1	As per programme no.			39.1mm width
2	Gun Drilling Work Completed On			26mm Deep
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	6.5mm/7.0mm	6.5mm All Rows 255mm	Row 27
3	External Relief Depth		7.0mm All Rows 230mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		21 3 25	
Inspected By (Sign) & Date			Ravi 21/3/25	

Reviewed by (Engineer-CNC)

Manager-QA