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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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14384	35/63/78
2	Machined By		V.T.L. H/c Shop	Dy. No. 120
3	Pallet Die No.		14217 (6.0) H/c	Rev 202
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 H/c / 632 H/c	Step 0.2: 630.5 H/c / 543 H/c
6	Inside Diameter	Drg. No.	480.12 H/c / 489.12 / 500.12 H/c	Step length: 26 H/c / 16.5 H/c
7	Width of Pellet Die	Drg. No.	182 H/c	
8	Grooves as per Drawing	Drg. No.	37 x 12 x 8 x 9.5 H/c / 27 x 12 x 8 x 9.5 H/c	
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 = 4
12	Tapping PCD		540 H/c	
13	Tapping Hole Diameter		H/c 2. Block by H/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and	1st Side One Slot
15	Tapping Hole Depth		Drill Depth 28.2 H/c	Tapping Depth 26.4
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 20/3/25	1 Slot
1	As per programme no.			28.1 H/c width
2	Gun Drilling Work Completed On			17 H/c Depth
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 10
2	External Relief Dia	6.5 H/c / 7.0 H/c	6.5 H/c All Rows - 43 H/c	
3	External Relief Depth		7.0 H/c All Rows - 15 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		20 3 25	
Inspected By (Sign) & Date			Ravi 20/3/25	

Reviewed by (Engineer-CNC)

Manager-QA