

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.		14446	32/50
2	Machined By		V. T. L. H/c Shop	Dr. No. 12.02.19
3	Pallet Die No.		14120(4.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	700 H/c	Step length 17.5
6	Inside Diameter	Drg. No.	600.12 H/c	
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12.5 x 8 x 7 H/c	12.5 x 8 x 7 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping H/c
12	Tapping PCD		645 H/c	of Holes - 12
13	Tapping Hole Diameter		M20 Check by H20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.3 H/c	Tapping Depth 20.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Rao: 24/3/25	
1	As per programme no.			
2	Gun Drilling Work Completed On			
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	4.5 H/c	Outside 23-35	Inner 18 H/c
3	External Relief Depth		22 H/c	
4	Inspection Done Before Hardening By (Name)		Rao	
5	Material Sent For Hardening By (Name)		Lark furnace	
6	Material Sent For Hardening On Date		24 3 25	
Inspected By (Sign) & Date			Rao: 24/3/25	

Reviewed by (Engineer-CNC)

Manager-QA