

Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9436

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.		14428 ✓	28/38/66
2	Machined By		V.T.L. H/c Shop	Qty No. 1-80, 809
3	Pallet Die No.		14744 (G.O) H/c	Rev 03
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	380.7 mm	Step 00, 393 mm
6	Inside Diameter	Drg. No.	546.12 mm (P. Box - 548.4 mm)	Step length = 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut = 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm	32.7 x 9.2 mm (4 x 8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 mm Deep
11	Tapping Operator		H/c Shop	Both Side
12	Tapping PCD		619 mm	Tapping H/c
13	Tapping Hole Diameter		H162 Check by H16 B.12	of H-162
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.2 mm	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 28/3/25	
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				Counter 30
1	Counter Sinking Depth & Finish	ok		Row 12
2	External Relief Dia	6.5 mm / 7.0 mm	6.5 mm All Rows 2 38 mm	
3	External Relief Depth		7.0 mm All Rows 2 38 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date			Ravi 28/3/25	

Reviewed by (Engineer-CNC)

Manager-QA