

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)

9450

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14467	33/66
2	Machined By		V.T.L. n/c Shop	1 Dy 12 (2.0) 69
3	Pallet Die No.		13520 (6.0) n/c	Rev 02
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c Step 00: 693 n/c	Tapped 8°
6	Inside Diameter	Drg. No.	546.12 n/c (Bor = 548.4 n/c)	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 n/c 32 x 7 x 9.2 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		M16.2 Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.2 n/c	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/3/25

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 Boi

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	7.5 n/c		All Rows					
3	External Relief Depth			33 n/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Shri Keshav					
6	Material Sent For Hardening On Date		25	3	25				

Inspected By (Sign) & Date

Ravi 25/3/25

Reviewed by (Engineer-CNC)

Manager-QA