

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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

9441

Check Parameter	Specification	Observations	Remarks
1 Work Order No.		14344	31/40
2 Machined By		V. T. L. H/c. Shop	Dy. H/c. (S.O.) 574
3 Pallet Die No.		14355 (2.8) H/c.	Rev. 2009
4 Die Category	Drg. No.	Junior	
5 Out Side Diameter	Drg. No.	38.5 H/c. Step 002 38.3 H/c.	Step length 9.5
6 Inside Diameter	Drg. No.	30.4.12 H/c. 30.5.12 H/c.	
7 Width of Pellet Die	Drg. No.	1.27 H/c.	step TD
8 Grooves as per Drawing	Drg. No.	8x6x3 H/c. 8x6x3 H/c.	Rework
9 Fitting Sizes on CNC Plate	Drg. No.	ok	in final sizes
10 Drilling Area Surface Smoothness		ok	
11 Tapping Operator		H/c. Shop	Tapping H/c.
12 Tapping PCD		350 H/c.	of holes 8
13 Tapping Hole Diameter		H12.2 Check by H12 B.12	Both Side
14 Tapping On Second Side	Half pitch of 1st side	ok	
15 Tapping Hole Depth		Drill Depth 18.2 H/c. Tapping Depth 18.6	
16 Perpendicularity of Tapped Hole		yes	
17 Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date		Ravi 22/3/25	
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 Go
2 External Relief Dia	3.3 H/c.	Outside (2-2)	Inner
3 External Relief Depth		15 H/c.	9 H/c.
4 Inspection Done Before Hardening By (Name)		Ravi	
5 Material Sent For Hardening By (Name)		Lark Purnace	
6 Material Sent For Hardening On Date		22 3 25	
Inspected By (Sign) & Date		Ravi 22/3/25	

Reviewed by (Engineer-CNC)

Manager-QA