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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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14567	40/40
2	Machined By		V.T.L H/c Shop	Drg No. 18.02 474
3	Pallet Die No.		14328 (4.0) H/c	Reo 200
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	390.9 H/c Step OD = 388 H/c	Step length 9.5
6	Inside Diameter	Drg. No.	310.12 H/c / 311.12 H/c	Step ID
7	Width of Pellet Die	Drg. No.	146 H/c	Rework
8	Grooves as per Drawing	Drg. No.	15x8x3 H/c / 15x8x3 H/c	in final H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	[Tapping H/c of holes 8]
11	Tapping Operator		H/c Shop	[Both Side]
12	Tapping PCD		356 H/c	
13	Tapping Hole Diameter		0.12" and 0.14" - Check by 0.12" / 0.14" Tapping Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 H/c	Tapping Depth 16.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 5/4/25	
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 (2-2)	Inner
3	External Relief Depth		4 H/c	Null
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		5 4 25	
Inspected By (Sign) & Date			Ravi 5/4/25	

Reviewed by (Engineer-CNC)
3/4/25

Manager-QA