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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

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14653	35/63/78
2	Machined By		V.T.L. M/c Shop	Drg No. 1-3-D-896
3	Pallet Die No.		14214 (6.0) M	Rev. 02
4	Die Category	Drg. No.	M. Tomb	
5	Out Side Diameter	Drg. No.	636 M / 638 M / Step 00	630.5 M / 543 M
6	Inside Diameter	Drg. No.	480.12 M / 489.1 M / 500.12 M	Step length 28 M
7	Width of Pellet Die	Drg. No.	182 M	16.5 M
8	Grooves as per Drawing	Drg. No.	37x12x8x9.5 M / 27x12x8x9.5 M	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	Tapping Holes
12	Tapping PCD		540 M	of holes 4
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and other Side one Slot	
15	Tapping Hole Depth		Drill Depth 28.4 M - Tapping Depth 28.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 13/4/25	1 Slot
1	As per programme no.			28.1 M width
2	Gun Drilling Work Completed On			17 M Deep
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	6.5 M / 9.0 M	6.5 M All Rows = 43 M	
3	External Relief Depth		7.0 M All Rows = 15 M	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purrace	
6	Material Sent For Hardening On Date		13 4 25	
Inspected By (Sign) & Date			Ravi 13/4/25	

Reviewed by (Engineer-CNC)

Manager-QA