

Lark Engineering Company (India) Pvt. Ltd.

Form No.

CNC/QA/FM/02

Rev. No.

01

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14630 ✓	3366 ✓
2	Machined By		V. T. L. n/c Shop	Drg No. 1.8.9.809
3	Pallet Die No.		14813 (6.0) n/c	Rev 003
4	Die Category	Drg. No.	M. Junibo	
5	Out Side Diameter	Drg. No.	680.7 n/c	Step 00.392.8 n/c, Tapper 8"
6	Inside Diameter	Drg. No.	546.12 n/c	(Box = 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.	32.7 x 9.2 n/c	32.7 x 9.2 n/c (4 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	[Face side Step]
10	Drilling Area Surface Smoothness		ok	[2nd Deep Btm]
11	Tapping Operator		n/c Shop	Side
12	Tapping PCD		619 n/c	[Tapping No. of holes = 2]
13	Tapping Hole Diameter		M16, Check by M16 Bolt	[Bottom Side]
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.8
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 15/4/25	
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 30"	
2	External Relief Dia	7.5 n/c	Row 2 12	
3	External Relief Depth		All Rows 33 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porreane	
6	Material Sent For Hardening On Date		15 25	
Inspected By (Sign) & Date			Ravi 15/4/25	

Reviewed by (Engineer-CNC)

Manager-QA