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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

Rev. Date

31-07-2013

Inprocess Inspection (Pellet Dies)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14834	25/4/16
2	Machined By		V. T. L. H/C Shop	Dr H. 28.2.11
3	Pallet Die No.		14547 (G.O) H	Rev. 0
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H, Step 00, 792 H, Step length 26.5	
6	Inside Diameter	Drg. No.	660.12 H	Under cut 6 H
7	Width of Pellet Die	Drg. No.	324 H	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H / 21.5 x 8 x 8 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		725 H	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 31.4 H Tapping Depth 29.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 26/4/25	28101
1	As per programme no.			32.1 H width
2	Gun Drilling Work Completed On			8 H Deep
3	Hole Finish In Gun Drilling	Marked	ok	Both Side
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 H / 7.0 H	6.5 H All Rows 2 35 H	Row 2 34
3	External Relief Depth		7.0 H All Rows 2 20 H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Royane	
6	Material Sent For Hardening On Date		26 4 25	
Inspected By (Sign) & Date			Ravi 26/4/25	

Reviewed by (Engineer-CNC)

Manager-QA