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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.		14819	25/45
2	Machined By		V. T. L. n/c Shop	Qty 4.2.2 = 483
3	Pallet Die No.		15192 (4.0) n/c	Revol 4
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	4.00 n/c Step 00. 389 n/c	Step length 10.5
6	Inside Diameter	Drg. No.	310.12 n/c	
7	Width of Pellet Die	Drg. No.	134 n/c	
8	Grooves as per Drawing	Drg. No.	8x7x3 n/c 8x7x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	[Tapping n/c of hole in 8 Both Side]
12	Tapping PCD		350 n/c	
13	Tapping Hole Diameter		1/2" = Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 17.6 n/c Tapping Depth 15.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 21/5/25	
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 6"	
2	External Relief Dia	4.5 n/c	Outside 2-2	Inner 20 n/c
3	External Relief Depth		24 n/c	20 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		2	5 25
Inspected By (Sign) & Date			Ravi 21/5/25	

Subje
21/5/25

Reviewed by (Engineer-CNC)

Manager-QA