

10115

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15214	30/66
2	Machined By		V. J. L. H/c Shop	Dy. No. 12.0 = 390
3	Pallet Die No.		15327 (6.0) H/c	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.2 H/c	Step 00.2 (393 H/c) Tappet 28
6	Inside Diameter	Drg. No.	546.14 H/c	(1.302 = 548.2 H/c) Step Length 31
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/c / 32.7 x 9.1 H/c (478)	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	
13	Tapping Hole Diameter		H/c = Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.4 H/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi: 19/6/25	
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.		Counters 30°
2	External Relief Dia	7.0 H/c	All Rows	Rows 12
3	External Relief Depth		36 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi:	
5	Material Sent For Hardening By (Name)		Lark Porname	
6	Material Sent For Hardening On Date		19 6 25	
Inspected By (Sign) & Date			Ravi: 19/6/25	

Reviewed by (Engineer-CNC)

Manager-QA