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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.		15325 ✓	33/53/70 ✓
2	Machined By		V. T. L. n/c Shop	Drg. No. 12.0.377
3	Pallet Die No.		15374 (G-8) n/c	Rev. 03 ✓
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	688 n/c Shop 002 697.7 n/c	Tubbers 5
6	Inside Diameter	Drg. No.	546.12 n/c (B-2 548.34) Step length 28.5	
7	Width of Pellet Die	Drg. No.	215 n/c	① Groden cut 1.98 n/c
8	Grooves as per Drawing	Drg. No.	29.5 x 10 x 9.1 n/c 29.5 x 10 x 9.1 n/c (G-8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face Side Step 1 n/c Drill Both Side]
11	Tapping Operator		n/c Shop	
12	Tapping PCD		618 n/c	[Tapping Holes of holes 2 Both Side]
13	Tapping Hole Diameter		M16. Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 32.4 n/c	Tapping Depth 30.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 4/8/25	
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 30.1	
2	External Relief Dia	6.5 n/c 7.3 n/c	6.5 n/c	All Pores 237 n/c
3	External Relief Depth		7.3 n/c	All Pores 212 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		4	7 25
Inspected By (Sign) & Date			Ravi 4/8/25	

Reviewed by (Engineer-CNC)

Manager-QA