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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.		15794	39/47
2	Machined By		V.T.L. H/O Shop	Dr H.L.R. 350
3	Pallet Die No.		14577 (4.0) H	Rev. 00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	694 H	Step 00 = 698 H
6	Inside Diameter	Drg. No.	600.14 H	Step length = 17.8
7	Width of Pellet Die	Drg. No.	222 H	
8	Grooves as per Drawing	Drg. No.	14x8x7 H / 14x8x7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/O Shop	Tapping H.O. of H.L.R. 12
12	Tapping PCD		640 H	B.H. Side
13	Tapping Hole Diameter		H20. Check by H20 B. 12	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 22.4 H	Tapping Depth 20 H
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 27/8/25	
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 Go
2	External Relief Dia	4.5 H	23-35	Inner
3	External Relief Depth		19 H	15 H
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		27 8 25	
Inspected By (Sign) & Date			Ravi 27/8/25	

Reviewed by (Engineer-CNC)

Manager-QA