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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.		14038	40/46
2	Machined By		V.T.L. n/c. Shop	Dy No. 62029 75
3	Pallet Die No.		14727 (G.O) n/c	Rev. no
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	409.9 n/c, Step 002 382.8 n/c	Step length 10.5
6	Inside Diameter	Drg. No.	315.12 n/c 318.12 n/c	STEP FD
7	Width of Pellet Die	Drg. No.	108 n/c	Rework
8	Grooves as per Drawing	Drg. No.	4 x 5 x 3 n/c 4 x 5 x 3 n/c	in final n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c. Shop	Tapping No. of Holes 8
12	Tapping PCD		350 n/c	Back Side
13	Tapping Hole Diameter		3/12" - Check by 3/12" Tap	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 12.2 n/c	Tapping Depth 10.4 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 5/4/25	
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 Sink Rev. 11
2	External Relief Dia	6.5 n/c	Outside (2.2)	Inner
3	External Relief Depth		10 n/c	6 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		5 4 25	
Inspected By (Sign) & Date			Ravi 5/4/25	

Reviewed by (Engineer-CNC)

Manager-QA