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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.		14735	66/66
2	Machined By		V. T. L. n/c Shop	By H. 13.07.09
3	Pallet Die No.		14976(12.0) n/c	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c Step 00: 693 n/c	Tapbar 8
6	Inside Diameter	Drg. No.	546.12 n/c (Ber. 548.4 n/c)	Step length 3 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Under cut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 n/c 32.7 x 9.2 n/c (4 x 8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Fore Side Step
10	Drilling Area Surface Smoothness		ok	2mm Deep Both Side
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	Tapping Ho
13	Tapping Hole Diameter		M16. Check by M16 Ball	of hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 33.4 n/c	Tapping Depth 31.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 22/4/25	
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 6
2	External Relief Dia		No Relief	Rev 6
3	External Relief Depth			
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Burnard	
6	Material Sent For Hardening On Date		22 4 25	
Inspected By (Sign) & Date			Ravi 22/4/25	

Reviewed by (Engineer-CNC)

Manager-QA