

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.			
2	Machined By		14928	38/46/105
3	Pallet Die No.		V.T.L. H/c Shop	Dy. 11. 18. 119
4	Die Category	Drg. No.	15461 (G.0) H/c	Rev. 00
5	Out Side Diameter	Drg. No.	S. Jumbo	445
6	Inside Diameter	Drg. No.	1059.7 H/c	Step 05. 1077 H/c
7	Width of Pellet Die	Drg. No.	848.14 H/c	(Box 2850.5 H/c)
8	Grooves as per Drawing	Drg. No.	266 H/c	Lead 0.001, 3.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	45x8x9.2 H/c	(8x8) H/c
10	Drilling Area Surface Smoothness		ok	Face Side
11	Tapping Operator		H/c Shop	2 H/c Deep
12	Tapping PCD		952 H/c	Both Side
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Tapping H/c
14	Tapping On Second Side	Half pitch of 1st side	ok	of Hole. 2
15	Tapping Hole Depth		Drill Depth. 42.3 H/c	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/5/25

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 2 Bo
2	External Relief Dia	7.0 H/c	7.5 H/c	7.0 H/c	All Rows	267 H/c				Row - 16
3	External Relief Depth			7.5 H/c	All Rows	59 H/c				
4	Inspection Done Before Hardening By (Name)									
5	Material Sent For Hardening By (Name)									
6	Material Sent For Hardening On Date			26	5	25				

Inspected By (Sign) & Date

Ravi 26/5/25

Reviewed by (Engineer-CNC)

Manager-QA