



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)

9875

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14923,	45/50,
2	Machined By		V. T. L. n/c Shop	Qty 100 L.F. 1007
3	Pallet Die No.		14551(3.5) n/c	Renewal
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	76 n/c, Step 00, 79.9 n/c	Step length 27
6	Inside Diameter	Drg. No.	66.14 n/c	Under size 16 n/c
7	Width of Pellet Die	Drg. No.	324 n/c	
8	Grooves as per Drawing	Drg. No.	21x8x10 n/c / 21x8x10 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		72.5 n/c	
13	Tapping Hole Diameter		M20, Check by M20 Bolt	Tapping n/c of holes = 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 27.3 n/c	Tapping Depth 25.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 15/5/25	2 S.I.T
1	As per programme no.			32.1 n/c hole
2	Gun Drilling Work Completed On			9 n/c Deep
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				Counter B ²
1	Counter Sinking Depth & Finish	OK		Row 52
2	External Relief Dia	4.0 n/c	Outside (3-3)	Inner
3	External Relief Depth		12 n/c	5 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		15 5 25	
Inspected By (Sign) & Date			Ravi 15/5/25	

Satya 15/5/25

Reviewed by (Engineer-CNC)

Manager-QA