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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.		14472	23/47
2	Machined By		V. T. L. n/c Shop	By H. 18.0.1042
3	Pallet Die No.		12983 (G.O) n/c	Rev 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1004 n/c, Step 00 - 1022.8 n/c	Tabber 8'
6	Inside Diameter	Drg. No.	848.12 n/c 850.6 n/c	Step length 45 n/c
7	Width of Pellet Die	Drg. No.	268 n/c	Lock cut 9.9 n/c
8	Grooves as per Drawing	Drg. No.	45x6x11 n/c 45x6x9.8 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 n/c Deep
11	Tapping Operator		n/c Shop	Both Side
12	Tapping PCD		929 n/c	Tapping n/c
13	Tapping Hole Diameter		M20, Check by M20 Ball	of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Sides
15	Tapping Hole Depth		Drill Depth 35.2 n/c	Tapping Depth 33.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 1/8/25

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

Counter 20

1	Counter Sinking Depth & Finish	OK							Row 1 B
2	External Relief Dia	7.5 n/c			All Rows				
3	External Relief Depth				54 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Porroce				
6	Material Sent For Hardening On Date				4 25				

Inspected By (Sign) & Date

Ravi 1/4/25

S. T. 1/4/13

Reviewed by (Engineer-CNC)

Manager-QA