

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)

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14546	39/50
2	Machined By		UTL MIC Shop	Eng No. Lark/870
3	Pallet Die No.		14475 (3.5 mm)	
4	Die Category	Drg. No.	SSEW	
5	Out Side Diameter	Drg. No.	60 mm, step on 61.9 mm	Step length 19.5
6	Inside Diameter	Drg. No.	58.0 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm / 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		ULC Shop	
12	Tapping PCD		565 mm	
13	Tapping Hole Diameter		H20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.2 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Makeesh 4/4/25

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

Counter 60

1	Counter Sinking Depth & Finish	OK						Row 35
2	External Relief Dia	3-8 mm	out side (3-3)		Inner			
3	External Relief Depth		18 mm		11 mm			
4	Inspection Done Before Hardening By (Name)		makeesh					
5	Material Sent For Hardening By (Name)		Lark Furnace					
6	Material Sent For Hardening On Date		04	04	25			

Inspected By (Sign) & Date

makeesh 04/04/25

Satish 4/4/25

Reviewed by (Engineer-CNC)

Manager-QA