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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.		14551	L10/50
2	Machined By		V.T.C. N/C Shop	Dry H. 12.0.450
3	Pallet Die No.		14997 (4.0) H/H	2002.00
4	Die Category	Drg. No.	740	
5	Out Side Diameter	Drg. No.	730 H/H Step 00. 743.5 H/H	Tapping 1.0
6	Inside Diameter	Drg. No.	690.12 H/H	Step long 1.23 H/H
7	Width of Pellet Die	Drg. No.	290 H/H	Under rest 6.75
8	Grooves as per Drawing	Drg. No.	15 x 8 x 5 H/H 15 x 8 x 5 H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping N.
12	Tapping PCD		685 H/H	g Holes 18
13	Tapping Hole Diameter		M20. Check by M20 B-12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/H	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 25/4/25	
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 - 1 Hole. Closed	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK	Counter 60	
2	External Relief Dia	4.5 H/H	Outside (25-3)	Inner
3	External Relief Depth	14 H/H	10 H/H	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		25	4 25
Inspected By (Sign) & Date			Ravi 25/4/25	

Satyam
Reviewed by (Engineer-CNC)

Manager-QA