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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.		14904 ✓	35/53/75
2	Machined By		V. T. L. H/c Shop	Dr 12.2.82
3	Pallet Die No.		13641 (B.O) H/c	Rev. 00
4	Die Category	Drg. No.	M 782	
5	Out Side Diameter	Drg. No.	722 H/c, Step 00, 777 H/c	778 H/c / 675 H/c
6	Inside Diameter	Drg. No.	572.14 H/c	Step length 42 H/c
7	Width of Pellet Die	Drg. No.	270 H/c	24.5 H/c
8	Grooves as per Drawing	Drg. No.	106 x 8 x 12 H/c 88 x 8 x 12 H/c	Under Cut 27.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes 8
12	Tapping PCD		660 H/c	
13	Tapping Hole Diameter		Ø3/4" 2 Check by Ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one Side Tapping and 2nd Side One side	
15	Tapping Hole Depth		Drill Depth 35.2 H/c Tapping Depth 33.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/5/25

131.5

1	As per programme no.		_____	39.1 H/c width
2	Gun Drilling Work Completed On		_____	26 H/c Deep
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 2 Go

1	Counter Sinking Depth & Finish	ok						Row 2 7
2	External Relief Dia	3.5 H/c 7.0 H/c	6.5 H/c	All Rows 2 40 H/c				
3	External Relief Depth		7.0 H/c	All Rows 2 80 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Purvare				
6	Material Sent For Hardening On Date		23	5	25			

Inspected By (Sign) & Date

Ravi 23/5/25

Reviewed by (Engineer-CNC)

Manager-QA