



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.		12994	40/55
2	Machined By		N.T.L. H/C Shop	Drg No 1302355
3	Pallet Die No.		13608(4.0) H/C	Rev 2.0
4	Die Category	Drg. No.	388-10	
5	Out Side Diameter	Drg. No.	630 H/C Step OD: 612 H/C	Step length 2.5mm
6	Inside Diameter	Drg. No.	520.12 H/C	
7	Width of Pellet Die	Drg. No.	186 H/C	
8	Grooves as per Drawing	Drg. No.	13x8x3 H/C 13x8x3 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping No of Holes = 12 Back Side
12	Tapping PCD		565 H/C	
13	Tapping Hole Diameter		H2 = 2 Check by H2 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm	Tapping Depth 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/10/24

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 - Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counters 60°
Row = 25

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner		
3	External Relief Depth	✓	19 H/C		15 H/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		23	10	24		

Inspected By (Sign) & Date

Ravi 23/10/24

Satyam 23/10/24

Reviewed by (Engineer-CNC)

Manager-QA