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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.		13676	44/50
2	Machined By		N.T.L. M/c Shop	Drg No. 1-3-D-1101
3	Pallet Die No.		13883 (4.0) M/c	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	403 M/c, Step on 380.7 M/c / 381.7 M/c	
6	Inside Diameter	Drg. No.	303.1 M/c / 304.12 M/c (Burr 303.12) Step length 10.5	
7	Width of Pellet Die	Drg. No.	95 M/c	
8	Grooves as per Drawing	Drg. No.	9x6x3 M/c / 9x6x3 M/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	Tapping M/c of holes, 16 Both side
12	Tapping PCD		350 M/c	
13	Tapping Hole Diameter		M14, Check by M14 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 15.3 M/c Tapping Depth 13.5	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 4/1/25

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							
2	External Relief Dia	4.5 M/c	outside (2.2)		Inner				
3	External Relief Depth		14 M/c		6 M/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			4	1	25			

Inspected By (Sign) & Date

Ravi 4/1/25

Ravi 4/1/25

Reviewed by (Engineer-CNC)

Manager-QA