

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)

9495

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14279	55/67
2	Machined By		N. T. L. H/c Shop	Dry No. 1-8-2
3	Pallet Die No.		14497 (8.0) H/c	Rev 2.02
4	Die Category	Drg. No.	N. T. L. H/c	
5	Out Side Diameter	Drg. No.	680 H/c	Step 002 692.2 H/c
6	Inside Diameter	Drg. No.	546.1 H/c	Step length 82 H/c
7	Width of Pellet Die	Drg. No.	178 H/c	Under cut 4.75 H/c
8	Grooves as per Drawing	Drg. No.	30x7x8 H/c	30x7x8 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 = 8
12	Tapping PCD		619 H/c	Both Side
13	Tapping Hole Diameter		1/2" = Check by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30 H/c	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Soni 21/4/25	
1	As per programme no.			One Drill
2	Gun Drilling Work Completed On			Hole Size
3	Hole Finish In Gun Drilling	Marked	OK	Ø 35 H/c
4	Defective Holes (If Any)		No	Depth 224 H/c
Note : Mark the defective holes/Missed holes with the help of Permanent Marker			Both Side	
1	Counter Sinking Depth & Finish	OK		Counter 30
2	External Relief Dia	9.0 H/c	All Rows	Row 9
3	External Relief Depth		12 H/c	
4	Inspection Done Before Hardening By (Name)		Soni	
5	Material Sent For Hardening By (Name)		Lark R. R. R. R. R.	
6	Material Sent For Hardening On Date		2 4 25	
Inspected By (Sign) & Date			Soni 21/4/25	

Reviewed by (Engineer-CNC)

Manager-QA