

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)

9477

No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14163	32/48/90
2	Machined By		N.T.L. H/c Shop	Qty. 12.0.728
3	Pallet Die No.		14759(6.0) H/c	Rev. 100
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c Step on 703 H/c	Tapping 4"
6	Inside Diameter	Drg. No.	600.12 H/c	Step length 88 mm
7	Width of Pellet Die	Drg. No.	221 H/c	
8	Grooves as per Drawing	Drg. No.	57x6x10 H/c 57x6x10 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
12	Tapping PCD		655 H/c	Both Side
13	Tapping Hole Diameter		1162 Check by H/c Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 24.2 H/c	Tapping Depth 28.0
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/3/25

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	6.5 H/c 7.0 H/c	6.5 H/c	All Rows = 5.8 H/c					
3	External Relief Depth		7.0 H/c	All Rows = 4.2 H/c					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Rurnore					
6	Material Sent For Hardening On Date		29	3	25				

Inspected By (Sign) & Date

Ravi 29/3/25

Reviewed by (Engineer-CNC)

Manager-QA