



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)

9549

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14579	30/50
3	Pallet Die No.		N.T.L. H/c Shop	Day No. 6.25-25.01
4	Die Category	Drg. No.	14403 (4.0) H/c	Revised
5	Out Side Diameter	Drg. No.	N.Tumbo	
6	Inside Diameter	Drg. No.	700 H/c Step 02: 892.8 H/c	Tabber 12
7	Width of Pellet Die	Drg. No.	600.12 H/c	Step length 12
8	Grooves as per Drawing	Drg. No.	222 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	12x2x7 H/c / 12x2x7 H/c	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		H/c Shop	Tapping H/c
13	Tapping Hole Diameter		640 H/c	g Holes 12
14	Tapping On Second Side	Half pitch of 1st side	H20: Check by H20 Bo	Both Side
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth 20.2 H/c	Tapping Depth 18.0
17	Visual Inspection Before Gun Drilling		Yes	
Inspected By (Sign) & Date			Ravi: 7/4/25	
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 - 1 Hole Colored	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		Counter Bo
2	External Relief Dia	4.5 H/c	20.8 H/c (2-3)	Inner
3	External Relief Depth		18 H/c	14 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		7	4
Inspected By (Sign) & Date			Ravi: 7/4/25	

Reviewed by (Engineer-CNC)

Manager-QA