



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

Form No.

9895
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.		14869	L10/45
2	Machined By		N.T.L. N/C Shop	Dy. 12.0.2013
3	Pallet Die No.		14376 (3.0) N/C	Rev. 00
4	Die Category	Drg. No.	N.T.L. N/C	
5	Out Side Diameter	Drg. No.	690 N/C	Tapping Holes
6	Inside Diameter	Drg. No.	600.12 N/C	Slip length 23.5
7	Width of Pellet Die	Drg. No.	250 N/C	Undercut 8.5 N/C
8	Grooves as per Drawing	Drg. No.	24x5x9 N/C / 24x5x9 N/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		655 N/C	
13	Tapping Hole Diameter		N/C Check by H16 Bolt	Tapping Holes of holes 12 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 24.3 N/C	Tapping Depth 22.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 19/5/25

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 Closed

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

1	Counter Sinking Depth & Finish	OK						Counter 60
2	External Relief Dia	3.5 N/C	Outside (3-3)		Inner			Low 41
3	External Relief Depth		11 N/C		5 N/C			
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		19	5	25			

Inspected By (Sign) & Date

Ravi 19/5/25

Reviewed by (Engineer-CNC)

Manager-QA