



Lark Engineering Company (India) Pvt. Ltd.

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

9921

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.		14867	45/60
2	Machined By		N.T.L. n/c Shop	Drg. No. 12.0.584
3	Pallet Die No.		14541 (8.0) n/c	Rev. 01
4	Die Category	Drg. No.	12.0.584	
5	Out Side Diameter	Drg. No.	720 mm Step 00. 798 mm	Tabbar 40
6	Inside Diameter	Drg. No.	660.14 mm	Step length 25.5
7	Width of Pellet Die	Drg. No.	324 mm	Under cut = 9
8	Grooves as per Drawing	Drg. No.	21.5 x 80 10 mm / 21.5 x 80 10 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		725 mm	
13	Tapping Hole Diameter		H20. Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 30.4 mm	Tapping Depth 28.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/5/25

1	As per programme no.			
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	ok	
4	Defective Holes (If Any)		ok	

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

Counter = 6

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	2.5 mm	outside (2-3)		Inner				
3	External Relief Depth		23 mm		15 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date		21	5	25				

Inspected By (Sign) & Date

Ravi 21/5/25

Reviewed by (Engineer-CNC)

Manager-QA