



Lark Engineering Company (India) Pvt. Ltd.

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

9930

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.		15004	55/55
2	Machined By		N. T. L. NLC Shop	Dy. M. L. S. 14924
3	Pallet Die No.		14049 (4.0) mm	Reason
4	Die Category	Drg. No.	Extrude	
5	Out Side Diameter	Drg. No.	629.7 mm ① Step 00.611.8 mm	Step length
6	Inside Diameter	Drg. No.	520.14 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.	13x8x5 mm 13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		NLC Shop	
12	Tapping PCD		58.5 mm	
13	Tapping Hole Diameter		M20, Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth: 20.4 mm	Tapping Depth: 18.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 22/5/25	
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	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	OK		
2	External Relief Dia	4.5 mm	Outside 3-35	Inner
3	External Relief Depth		5 mm	Mill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Engineer	
6	Material Sent For Hardening On Date		22	5 25
Inspected By (Sign) & Date			Ravi 22/5/25	

Reviewed by (Engineer-CNC)

Manager-QA