



Lark Engineering Company (India) Pvt. Ltd.

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

9929

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.		14955	30/55
2	Machined By		N.T.L. n/c Shop	Qty 4. 18.0. 347
3	Pallet Die No.		14048 (G.O) n/c	Rev. 00
4	Die Category	Drg. No.	2-draw die	
5	Out Side Diameter	Drg. No.	329.8 n/c	Step 00. 323.9 n/c
6	Inside Diameter	Drg. No.	520.14 n/c	Tabber 12
7	Width of Pellet Die	Drg. No.	222 n/c	Step length 12 n/c
8	Grooves as per Drawing	Drg. No.	13x8x5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	13x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		585 n/c	
13	Tapping Hole Diameter		n/c Check by N20. Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4 n/c	Tabbing Depth 18.5
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		Counter 260
2	External Relief Dia	2.5 n/c	Outside 23-37	Ravi 28
3	External Relief Depth		25 n/c	Inner 19 n/c
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		22 5 25	
Inspected By (Sign) & Date			Ravi 22/5/25	

Reviewed by (Engineer-CNC)

Manager-QA