

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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15005	48/48
2	Machined By		N.T.L. H/O Shop	Dy H. 12.0.13
3	Pallet Die No.		13137 (3.0) H	Rev. 00
4	Die Category	Drg. No.	SSS-10	
5	Out Side Diameter	Drg. No.	615.9 H, Step 00, 611.9 H	
6	Inside Diameter	Drg. No.	520.14 H	Step length 19.5
7	Width of Pellet Die	Drg. No.	182 H	
8	Grooves as per Drawing	Drg. No.	14x7x7 H / 14x7x7 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/O Shop	Tapping H. of hole 12
12	Tapping PCD		58.5 H	Both Side
13	Tapping Hole Diameter		H/O - Check by H/O Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.3 H Tapping Depth 18.6	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 24/5/25	
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 60
2	External Relief Dia	3.5 H	Outside (3-3)	Inner
3	External Relief Depth		4 H	Nill
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Ramesh	
6	Material Sent For Hardening On Date		24 5 25	
Inspected By (Sign) & Date			Ravi 24/5/25	

Sat 24/5/25

Reviewed by (Engineer-CNC)

Manager-QA