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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.		14973	36/50
2	Machined By		N.T.L. N/C Shop	Dy No. 14-0148-5
3	Pallet Die No.		14604 (3.0) N/C	Rev. 03
4	Die Category	Drg. No.	N7120	
5	Out Side Diameter	Drg. No.	700.9 N/C	Step 00. Tapper = 12°
6	Inside Diameter	Drg. No.	600.14 N/C	Step length 17.4 N/C
7	Width of Pellet Die	Drg. No.	265.8 N/C	
8	Grooves as per Drawing	Drg. No.	15.3 x 8 x 7 N/C	15.3 x 8 x 7 N/C
9	Fitting Sizes on CNC Plate	Drg. No.	ok	0.8 N/C Deep
10	Drilling Area Surface Smoothness		ok	Both Side
11	Tapping Operator		N/C Shop	Tapping Ho
12	Tapping PCD		640 N/C	of Holes. 16
13	Tapping Hole Diameter		H20. Check by H20 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 20.8 N/C	Tapping Depth. 18.7 N/C
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Raw: 28/5/25

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

Counter 26

1	Counter Sinking Depth & Finish	ok						Raw: 47
2	External Relief Dia	3.5 N/C	Outside (3-3)		Inner			
3	External Relief Depth		20 N/C		14 N/C			
4	Inspection Done Before Hardening By (Name)				Raw:			
5	Material Sent For Hardening By (Name)				Lark Purnace			
6	Material Sent For Hardening On Date		26	5	25			

Inspected By (Sign) & Date

Raw: 28/5/25

Reviewed by (Engineer-CNC)

Manager-QA