



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)

9962

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		15036	40/60
2	Machined By		N.T.L. H/C Shop	1 Dy H., 18.02.13
3	Pallet Die No.		14544 (6.0) H/C	Rev. 01
4	Die Category	Drg. No.	Mumba	
5	Out Side Diameter	Drg. No.	780 H/C Shop 001 792.9 H/C	Tapping H.
6	Inside Diameter	Drg. No.	660.14 H/C	Step length 4.35
7	Width of Pellet Die	Drg. No.	323.8 H/C	Undercut 9 H/C
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 10 H/C / 21.5 x 8 x 10 H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	Tapping H.
12	Tapping PCD		725 H/C	of H. 12
13	Tapping Hole Diameter		H20, Check by H2 Ball	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 30.4 H/C	Tapping Depth 38
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 28/5/25	28.1
1	As per programme no.			32.1 H/C width
2	Gun Drilling Work Completed On			8 H/C Depth
3	Hole Finish In Gun Drilling	Marked	OK	Both Side
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 H/C	20.8 H/C (3-3)	Low 34
3	External Relief Depth		26 H/C	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Purace	
6	Material Sent For Hardening On Date		28 5 25	
Inspected By (Sign) & Date			Ravi 28/5/25	

Reviewed by (Engineer-CNC)

Manager-QA