



Lark Engineering Company (India) Pvt. Ltd.

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

10449

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.		15609	32/50
2	Machined By		N.T.L. H/c Shop	Dy. H. Lark
3	Pallet Die No.		13257(2.8) H/c	
4	Die Category	Drg. No.	SSS70	
5	Out Side Diameter	Drg. No.	619.9 H/c	Step 00, 611.8 H/c
6	Inside Diameter	Drg. No.	520.14 H/c	
7	Width of Pellet Die	Drg. No.	186 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c	13x8x5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		565 H/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 20.4 H/c	Tapping Depth
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sai: 8/8/25	
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	3.1 H/c	Outside 23-33	Inner 18 H/c
3	External Relief Depth		23 H/c	18 H/c
4	Inspection Done Before Hardening By (Name)		Sai:	
5	Material Sent For Hardening By (Name)		Lark Purnace	
6	Material Sent For Hardening On Date		8 8 25	
Inspected By (Sign) & Date			Sai: 8/8/25	

Reviewed by (Engineer-CNC)

Manager-QA