



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.		15749	22/40
2	Machined By		N. T. L. H/c Shop	Drill 12.0.21
3	Pallet Die No.		15276 (2.8) H/c	Ream of
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 H/c Shop 00. 499 H/c	Tapping 13
6	Inside Diameter	Drg. No.	420.14 H/c	Step length 17 H/c
7	Width of Pellet Die	Drg. No.	158 H/c	
8	Grooves as per Drawing	Drg. No.	12-8-3 H/c / 12-8-3 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		454 H/c	
13	Tapping Hole Diameter		03/4" 2 Check by 0.4 H/c	Tapping H/c of holes 8 Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 H/c Tapping Depth 16.8 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 20/8/25

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						Counter 60
2	External Relief Dia	3.3 H/c	20.8 H/c		Inner			Ravi 26
3	External Relief Depth		20 H/c		18 H/c			
4	Inspection Done Before Hardening By (Name)				Ravi			
5	Material Sent For Hardening By (Name)				Lark Ravi			
6	Material Sent For Hardening On Date		20	8	25			

Inspected By (Sign) & Date

Ravi 20/8/25

Reviewed by (Engineer-CNC)

Manager-QA