



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.		15890	46/50
2	Machined By		N.T.L. n/c. Shop	Dy. H. L. 8.0/1376
3	Pallet Die No.		15606 (8.0) n/c	Rev. op
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52 n/c	Step OD = 490.9 n/c
6	Inside Diameter	Drg. No.	420.14 n/c	Step length = 17.5
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		M20. Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth. 18.3 n/c	Tapping Depth. 16.5
16	Perpendicularity of Tapped Hole		n/c	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rao: 3/9/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Ho

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	OK								Counter, 6
2	External Relief Dia	8.5 n/c	Outside (2.2)			Inner				Rao: 12
3	External Relief Depth		12 n/c			4 n/c				
4	Inspection Done Before Hardening By (Name)									Rao:
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date									

Inspected By (Sign) & Date

Rao: 3/9/25

Reviewed by (Engineer-CNC)

Manager-QA