



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.		15910	38/55
2	Machined By		N. T. L. H/c Shop	Dr H. 18.02.35
3	Pallet Die No.		14834 (4.0) H	Rev. 55
4	Die Category	Drg. No.	88810	
5	Out Side Diameter	Drg. No.	629.9 H (D) Step 00.611.9 H	Step length 00.611.9 H
6	Inside Diameter	Drg. No.	520.14 H	
7	Width of Pellet Die	Drg. No.	186 H	
8	Grooves as per Drawing	Drg. No.	13x8x3 H	
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	
13	Tapping Hole Diameter		H20, Check by H2-Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H	Tapping Depth 18.4
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Res: 17/9/25

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		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	4.5 H	Outside 3-31		Inner			Rev: 25
3	External Relief Depth	✓	21 H		17 H			
4	Inspection Done Before Hardening By (Name)		✓		Res:			
5	Material Sent For Hardening By (Name)				Lark Furnace			
6	Material Sent For Hardening On Date		9	25				

Inspected By (Sign) & Date

Res: 17/9/25

Reviewed by (Engineer-CNC)

Manager-QA