

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)

10873

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16294	35/40/66
2	Machined By		N. T. L. H/c Shop	Dy. H. L. S. 0320
3	Pallet Die No.		1647-5 (6.0) H/c	Rev. 08
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.144	Step 002 693 H/c - Tapper B
6	Inside Diameter	Drg. No.	546.12 H/c (130.548.2)	Step length 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut. 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c / 32 x 7 x 9.1 H/c (4 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side Step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep Both Side
11	Tapping Operator		H/c Shop	Tapping No
12	Tapping PCD		619 H/c	of Holes 2
13	Tapping Hole Diameter		H16 - Check by H16 G. 12	Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.4 H/c	Tapping Depth 31.9
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 14/10/25

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

Counter 30

1	Counter Sinking Depth & Finish	OK						Row 12
2	External Relief Dia	6.5 H/c 7.0 H/c	6.5 H/c	All Rows 2 31 H/c				
3	External Relief Depth		7.0 H/c	All Rows 2 98 H/c				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Rumar				
6	Material Sent For Hardening On Date		14	10	25			

Inspected By (Sign) & Date

Ravi 14/10/25

Reviewed by (Engineer-CNC)

Manager-QA