



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.		11535/	38/50/
2	Machined By		N.T.L. H/c Shop	1 Drg. no. 6-2-0-980
3	Pallet Die No.		11964 (3-0) H/c	Recess
4	Die Category	Drg. No.	Subsidiary	
5	Out Side Diameter	Drg. No.	620 H/c Step 002 Tapper 12° Step length 18.5	
6	Inside Diameter	Drg. No.	520.3 H/c 520.14 H/c	
7	Width of Pellet Die	Drg. No.	222 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		H/c Check by H/c Bolt	Tapping dia of H/c = 12 Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.8 H/c Tapping Depth 18.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 22/3/24

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 20
2	External Relief Dia	3.5 H/c	Outside (3-3)	Inner					Low = 38
3	External Relief Depth		18 H/c	12 H/c					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		22	3	24				

Inspected By (Sign) & Date

Ravi 22/3/24

Reviewed by (Engineer-CNC)
Sethi 22/3/24

Manager-QA