



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.		14003 ✓	31/40 ✓
2	Machined By		V.T.L. H/c Shop	Drg No. (3.0) = 865
3	Pallet Die No.		14208 (d.3) H/c	Rev = ∞
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	389.9 H/c, Step 02 = 389.9	Step length = 11.5
6	Inside Diameter	Drg. No.	310.12 H/c	
7	Width of Pellet Die	Drg. No.	135 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x3 H/c 12x8x3 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		350 H/c	Tapping No of Holes = 8 Both Side
13	Tapping Hole Diameter		Ø3/4" = Check by Ø3/4" Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.3 H/c	Tapping Depth = 18.6 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 25/11/25

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								
2	External Relief Dia	3.1 H/c	outside (2-2)		Inner					
3	External Relief Depth		15 H/c		9 H/c					
4	Inspection Done Before Hardening By (Name)				Ravi					
5	Material Sent For Hardening By (Name)				Lark Porrace					
6	Material Sent For Hardening On Date		25	1	25					

Inspected By (Sign) & Date

Ravi 25/11/25

Ravi 25/11/25

Reviewed by (Engineer-CNC)

Manager-QA