



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.		14344	40/40
2	Machined By		V.T.L. n/a Shop	Drilling No. 1.8.2=574
3	Pallet Die No.		14353 (3.5) n/a	Recess
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	385 n/a Step 00. 383 n/a	Step length 9.5
6	Inside Diameter	Drg. No.	304.12 n/a / 305.12 n/a	
7	Width of Pellet Die	Drg. No.	127 n/a	Step ID Rework
8	Grooves as per Drawing	Drg. No.	8x6x3 n/a / 8x6x3 n/a	in final size
9	Fitting Sizes on CNC Plate	Drg. No.	ok	M/City
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	Tapping No. of Holes 2 & Rota Side
12	Tapping PCD		350 n/a	
13	Tapping Hole Diameter		M12 2 Check by M12 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.2 n/a	Tapping Depth 16.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 12/3/25	
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 - 2 Hole Closed	
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	U.O n/a	Outside (2.2)	Row 17
3	External Relief Depth		4 n/a	Inner Mill
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		18 3 25	
Inspected By (Sign) & Date			Sasi 12/3/25	

Sasi 12/3/25

Reviewed by (Engineer-CNC)

Manager-QA