



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.		15134 ✓	40/45 ✓
2	Machined By		V.T.L. H/C Shop	Dr. H. 1.3.0.2835
3	Pallet Die No.		14365 (5.0) ✓	Renov ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	40.5 ✓, Step 0.289 ✓	Step length 9.5 ✓
6	Inside Diameter	Drg. No.	31.5.12 ✓	
7	Width of Pellet Die	Drg. No.	120 ✓	
8	Grooves as per Drawing	Drg. No.	1078 ✓ 3 ✓ / 1078 ✓ 3 ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/C Shop	Tapping H. of Holes 8
12	Tapping PCD		356 ✓	Both Side
13	Tapping Hole Diameter		0.314" ✓ Check by 0.314" B.H.	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 2.4 ✓ Tapping Depth 18.6 ✓	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 9/6/25	
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	5.5 ✓	Outside 22.2 ✓	Sasi ✓
3	External Relief Depth		10 ✓	Inner 5 ✓
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Porrace	
6	Material Sent For Hardening On Date		9 6 25	
Inspected By (Sign) & Date			Sasi 9/6/25	

Reviewed by (Engineer-CNC)

Manager-QA