



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.		15191 ✓	30/45 ✓
2	Machined By		V. T. L. H/c Shop	Day 24.18.1208
3	Pallet Die No.		14794(5.0) H/c	Revised
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	408 H/c, Step 002 384 H/c	Step length 10.0
6	Inside Diameter	Drg. No.	318.14 H/c	
7	Width of Pellet Die	Drg. No.	134 H/c	
8	Grooves as per Drawing	Drg. No.	12 x 5 x 3 H/c, 12 x 5 x 3 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	
13	Tapping Hole Diameter		0.12" & Check by 0.12" Tap	Tapping H/c of H/c. 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 16.6 H/c	Tapping Depth 14.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

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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 B. 1
2	External Relief Dia	5.5 H/c	20.5 H/c		Inner			Rev. 14
3	External Relief Depth		20 H/c		15 H/c			
4	Inspection Done Before Hardening By (Name)				Rev: 1			
5	Material Sent For Hardening By (Name)				Lark Porrace			
6	Material Sent For Hardening On Date		26	6	25			

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA