



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.		15741	45/45
2	Machined By		V.T.L. H/c Shop	Dr. H. 18.01.2013
3	Pallet Die No.		14792 (4.0) H	Rev 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	407.9 H, Step 00.383.9 H	Step 10.5
6	Inside Diameter	Drg. No.	318.14 H	
7	Width of Pellet Die	Drg. No.	134 H	
8	Grooves as per Drawing	Drg. No.	12x5x3 H / 12x5x3 H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tabbing of holes 8
12	Tapping PCD		350 H	Both Side
13	Tapping Hole Diameter		0.112" = Crack by 1/2" Tap	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.5 H	Tapping Depth 14.6
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 27/8/25	
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 Sink 18
2	External Relief Dia	4.5 H	Outside 2-2	Inner
3	External Relief Depth		8 H	Nil
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		27	8
Inspected By (Sign) & Date			Ravi 27/8/25	

Reviewed by (Engineer-CNC)

Manager-QA