



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)

9577

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14628	31/50
2	Machined By		V.T.L. H/c Shop	① Dag No. 1.8.0.450
3	Pallet Die No.		135-1 (2.8) H/c	Rev. 00
4	Die Category	Drg. No.	786	
5	Out Side Diameter	Drg. No.	730 H/c, Step 00, 743.4 H/c	Tapping 00
6	Inside Diameter	Drg. No.	630.2 H/c	Step length 2.8
7	Width of Pellet Die	Drg. No.	290 H/c	Under cut 6.75
8	Grooves as per Drawing	Drg. No.	15x8x5 H/c / 15x8x5 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		685 H/c	
13	Tapping Hole Diameter		H20 = Check by H20 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4 H/c	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 10/4/25

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

Counter Bore
Raw: 58

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	3.3 H/c	Outside (2.8-2)		Inner		
3	External Relief Depth		2.5 H/c		1.9 H/c		
4	Inspection Done Before Hardening By (Name)				Raw		
5	Material Sent For Hardening By (Name)				Lark Fornere		
6	Material Sent For Hardening On Date		10	4	25		

Inspected By (Sign) & Date

Raw: 10/4/25

Reviewed by (Engineer-CNC)

Manager-QA