



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)

8945

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13789	35/55
2	Machined By		V.T.L. H/c Shop	Dry hole 1.30 457
3	Pallet Die No.		13925 (3.5) H/c	Ran 200
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	770 H/c Step 0.2 800 H/c	Step length = 8 H/c
6	Inside Diameter	Drg. No.	660.12 H/c	Under cut = 15 H/c
7	Width of Pellet Die	Drg. No.	316 H/c	
8	Grooves as per Drawing	Drg. No.	20 x 8 x 7.5 H/c / 20 x 8 x 7.5 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of holes = 12 Botu Side
12	Tapping PCD		725 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 25.2 H/c	Tapping Depth 23.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 9/1/25

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 = 60°

1	Counter Sinking Depth & Finish	ok								Ran 251
2	External Relief Dia	4.0 H/c	Outside (3-3)		Inner					
3	External Relief Depth		24 H/c		20 H/c					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Furnace
6	Material Sent For Hardening On Date		9	1	25					

Inspected By (Sign) & Date

Ravi 9/1/25

Satya 9/1/25

Reviewed by (Engineer-CNC)

Manager-QA