



# 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)

9074

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14003 ✓	31/40 ✓
2	Machined By		V.T.L. n/c Shop	Drg No. 1.8.93 865
3	Pallet Die No.		14209 (2.8) n/c	Rev = 00 ✓
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	389.9 n/c	Step 00: 382.9 n/c, Step length 11.5
6	Inside Diameter	Drg. No.	310.12 n/c / 310.14 n/c ⊕	
7	Width of Pellet Die	Drg. No.	135 n/c ✓	
8	Grooves as per Drawing	Drg. No.	12x8x3 n/c / 12x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of holes: 8 Both Side
12	Tapping PCD		350 n/c ✓	
13	Tapping Hole Diameter		ø3/4" 2 C.back by ø3/4" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 20.3 n/c	Tapping Depth: 18.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

### Inspected By (Sign) & Date

Ravi 25/1/25

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-Gun

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	3.1 n/c	Outside (2-2)		Inner				
3	External Relief Depth		15 n/c		9 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Forrace				
6	Material Sent For Hardening On Date		25	1	25				

### Inspected By (Sign) & Date

Ravi 25/1/25

Satya 25/1/25

Reviewed by (Engineer-CNC)

Manager-QA