



# 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.		14025	55/55
2	Machined By		V.T.L n/c Shop	Drg No. 13161 53
3	Pallet Die No.		13161 (4.0) n/c	Rev. 2.00
4	Die Category	Drg. No.	7910	
5	Out Side Diameter	Drg. No.	740 n/c	Step OD 743.4 n/c
6	Inside Diameter	Drg. No.	630.12 n/c	Tapper 10°
7	Width of Pellet Die	Drg. No.	290 n/c	Step length 2.3 n/c
8	Grooves as per Drawing	Drg. No.	15x8x5 n/c	Under cut 2.75 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	15x8x5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping H <sub>2</sub>
13	Tapping Hole Diameter		685 n/c	of holes = 16
14	Tapping On Second Side	Half pitch of 1st side	H <sub>2</sub> Check by H <sub>2</sub> Bolt	Both Side
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Drill Depth 20.3 n/c	Tapping Depth 18.6 n/c
17	Visual Inspection Before Gun Drilling		yes	

### Inspected By (Sign) & Date

Ravi 13/2/25

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 60°
2	External Relief Dia	4.5 n/c	Outside (2-3)		Inner				Rev. 43
3	External Relief Depth		5 n/c		Null				
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Purware
6	Material Sent For Hardening On Date		13	2	25				

### Inspected By (Sign) & Date

Ravi 13/2/25

13/2/25

Reviewed by (Engineer-CNC)

Manager-QA