



Lark Engineering Company (India) Pvt. Ltd.

ITI, 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.		19744	35/40
2	Machined By		VTL M/c Shop	Drg No - Lark Std
3	Pallet Die No.		11995 (50mm)	P195
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500mm	Step length - 17.5mm
6	Inside Diameter	Drg. No.	490.12mm	
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12x8x3mm / 12x8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 8]
11	Tapping Operator		M/c Shop	[Both side]
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20 check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 06/09/14

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								Row - 17
2	External Relief Dia	5.5mm	outside (5-5)	Inner						
3	External Relief Depth		10mm	5mm						
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		06	09	14					

Inspected By (Sign) & Date

Ramanpreet Singh 06/09/14

Reviewed by (Engineer-CNC)

Manager-QA