



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.		12947	30/09/13
2	Machined By		V.T.L M/C Shop	Dr. No. 1.30.832
3	Pallet Die No.		12648 (5.0) mm	Rev 2.00
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	626 mm	Step OD: 624 mm
6	Inside Diameter	Drg. No.	520.12 mm	Step length: 17.9
7	Width of Pellet Die	Drg. No.	222 mm	Tapper: 12
8	Grooves as per Drawing	Drg. No.	13x8x5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	Tapping no. of Holes = 12
12	Tapping PCD		565 mm	Both Side
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 = 20.4 mm	Tapping Depth = 18.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/09/14

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

1	Counter Sinking Depth & Finish	OK	5.5 mm	6.0 mm	Counter - 60°
2	External Relief Dia		All Holes	All Holes	Row - 26
3	External Relief Depth		23 mm	11 mm	
4	Inspection Done Before Hardening By (Name)		Ravi		
5	Material Sent For Hardening By (Name)		Lark	Furnace	
6	Material Sent For Hardening On Date		30	09	24

Inspected By (Sign) & Date

Ravi 30/09/14

30/09/14

Reviewed by (Engineer-CNC)

Manager-QA