



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.		13612-44 ✓	32/40 ✓
2	Machined By		V.T.L. H/c Shop	Dy. No. Lark 9177
3	Pallet Die No.		12681(4.0)44 ✓	Rev. 2.00
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm, Step 00, 395 mm	Step length 11.5
6	Inside Diameter	Drg. No.	320.12 mm	
7	Width of Pellet Die	Drg. No.	142 mm	
8	Grooves as per Drawing	Drg. No.	15.5 x 7 x 2 mm / 15.5 x 7 x 2 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		355 mm	
13	Tapping Hole Diameter		M16 - Check by M16 Ball	Tapping H. of holes: 8 Botu Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.3 mm	Tapping Depth 19.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 17/12/14

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 - 1 Hole Coloc ed (4)

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter, Go!

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.5 mm	Outside (2-2)		Inner				Rev 2.16
3	External Relief Depth		12 mm		8 mm				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		17	12	24				

Inspected By (Sign) & Date

Ravi 17/12/14

Sats 17/12/14

Reviewed by (Engineer-CNC)

Manager-QA