



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.		13669	49/55
2	Machined By		V.T.L. n/c Shop	Drg No. 1.9.0 = 512
3	Pallet Die No.		13888 (3.8) n/c	Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	5.29.9 n/c	Step OD = 4.91 n/c
6	Inside Diameter	Drg. No.	4.20.12 n/c	Step length 17.5
7	Width of Pellet Die	Drg. No.	158 n/c	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 n/c	12 x 8 x 3 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping No. of holes 8 Both Side
12	Tapping PCD		454 n/c	
13	Tapping Hole Diameter		0.0314" 2 Check by 0.034" Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 18.3 n/c	Tapping Depth 15.9 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 21/12/14

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

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

Counter + 60

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3 n/c	00 Side (2-2)		Inner				
3	External Relief Depth		13 n/c		6 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Roxace				
6	Material Sent For Hardening On Date		21	12	24				

Inspected By (Sign) & Date

Ravi 21/12/14

Reviewed by (Engineer-CNC)

Manager-QA