



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13644	57/08 ✓
2	Machined By		V. T. L. N/C Shop	Drg No. 130.32
3	Pallet Die No.		13933 (10.0) ✓	Row 08 ✓
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	88.01 mm Step 00 - 692 mm	Tabber 8°
6	Inside Diameter	Drg. No.	546.12 mm (Bor - 548.12 mm)	Step length 31.4
7	Width of Pellet Die	Drg. No.	195 mm	Under cot. 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm 32 x 7 x 9.1 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Face Side Step 2 mm Deep Both Side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		619 mm	[Tapping No of Holes 2 Both Side]
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 33.3 mm Tapping Depth 31.8 mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/12/14

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								Row - 8
2	External Relief Dia	11.0 mm	All Rows							
3	External Relief Depth		9 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		28	12	24					

Inspected By (Sign) & Date

Ravi 28/12/14

Jatin 28/12/14

Reviewed by (Engineer-CNC)

Manager-QA