



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.		13807	37147
2	Machined By		N.T.L. N/C Shop	Dy. No. 1, 2, 3, 4, 5, 6, 7, 8, 9, 10, 11, 12, 13, 14, 15, 16, 17, 18, 19, 20, 21, 22, 23, 24, 25, 26, 27, 28, 29, 30, 31, 32, 33, 34, 35, 36, 37, 38, 39, 40, 41, 42, 43, 44, 45, 46, 47, 48, 49, 50, 51, 52, 53, 54, 55, 56, 57, 58, 59, 60, 61, 62, 63, 64, 65, 66, 67, 68, 69, 70, 71, 72, 73, 74, 75, 76, 77, 78, 79, 80, 81, 82, 83, 84, 85, 86, 87, 88, 89, 90, 91, 92, 93, 94, 95, 96, 97, 98, 99, 100
3	Pallet Die No.		12515(3.5)mm	Rev 02 mm
4	Die Category	Dr. No.	Extrawide	
5	Out Side Diameter	Dr. No.	614mm	Step 00, 612mm
6	Inside Diameter	Dr. No.	520.12 mm	Step length 12.5
7	Width of Pellet Die	Dr. No.	222 mm	
8	Grooves as per Drawing	Dr. No.	13x8x5 mm	13x8x5 mm
9	Fitting Sizes on CNC Plate	Dr. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		N/C Shop	
12	Tapping PCD		565 mm	Tapping No. of holes 12 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 20.2 mm	Tapping Depth 18.6 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 7/12/13	
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		Counter 60° Rev 35
2	External Relief Dia	4.0 mm	Outside (3.3)	Inner
3	External Relief Depth		14 mm	10 mm
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Pomare	
6	Material Sent For Hardening On Date		7 / 1 / 25	
Inspected By (Sign) & Date			Ravi 7/12/13	

Reviewed by (Engineer-CNC)

Manager-QA