



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)

9293

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.			
2	Machined By		14248 ✓	45/50 ✓
3	Pallet Die No.		V. T.L. n/c Shop	Dy. No. 12.0 976
4	Die Category	Drg. No.	14260 (8.0) n/c	Rev. 02 ✓
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	519.9 n/c Step 00, 491.8 n/c Step length	35 ✓
7	Width of Pellet Die	Drg. No.	420.12 n/c	
8	Grooves as per Drawing	Drg. No.	152 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	1145x3 n/c 1145x3 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		456 n/c ✓	Tapping No. of holes: 8 Both Side
13	Tapping Hole Diameter		Ø31" = Check by Ø31" Bit	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth: 18.2 n/c	Tapping Depth: 14.5 n/c ✓
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/15

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
Rows - 12

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	Ø.5 n/c	outside Ø2-25	inner		
3	External Relief Depth		13 n/c	5 n/c		
4	Inspection Done Before Hardening By (Name)		Ravi			
5	Material Sent For Hardening By (Name)		Lark Forrace			
6	Material Sent For Hardening On Date		27	2	25	

Inspected By (Sign) & Date

Ravi 27/7/15

27/7/15

Reviewed by (Engineer-CNC)

Manager-QA