



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.		14044 ✓	40/50
2	Machined By		V.T.L. n/c Shop	Dy No. 19.2.12
3	Pallet Die No.		14511 (8.0) n/c ✓	Rev. 00 ✓
4	Die Category	Drg. No.	Jowler	
5	Out Side Diameter	Drg. No.	415 n/c - Step 00 = 387.8 n/c	Step length 10 n/c
6	Inside Diameter	Drg. No.	315.12 n/c	
7	Width of Pellet Die	Drg. No.	145 n/c	
8	Grooves as per Drawing	Drg. No.	8x8x3 n/c 8x8x3 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop ✓	[Tapping side of holes & Both Side]
12	Tapping PCD		M12 = 360 n/c / $\phi 3/4" = 355 n/c$	
13	Tapping Hole Diameter		M12 = / $\phi 3/4" =$ Check by M12 / $\phi 3/4"$ Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping M12 and	1st Side $\phi 3/4"$
15	Tapping Hole Depth		Drill Depth = 20.2 n/c	Tapping Depth = 18.0
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/8/13

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

Counter 60
Rev. 11

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	8.5 n/c	outside (2-2)	Inner			
3	External Relief Depth		15 n/c	10 n/c			
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Purrace				
6	Material Sent For Hardening On Date		27	2	25		

Inspected By (Sign) & Date

Ravi 27/8/13

Reviewed by (Engineer-CNC)
Satyam 27/8/13

Manager-QA