



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9667

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.		14611	37/40
2	Machined By		V. T. L. H/C Shop	By H. S. C. 1562
3	Pallet Die No.		13994 (3.5) mm	Revised
4	Die Category	Drg. No.	Sentor	
5	Out Side Diameter	Drg. No.	500 mm	Step 002 498.8
6	Inside Diameter	Drg. No.	42.12 mm	Tap 12
7	Width of Pellet Die	Drg. No.	158 mm	Core Tap 03 Step length 18 mm
8	Grooves as per Drawing	Drg. No.	12 x 8 = 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 x 8 = 3 mm	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		H20. Check by H20 Bolt	Tapping H/C of holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 18.3 mm	Tapping Depth 18.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Raw: 19/4/15

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

1	Counter Sinking Depth & Finish	OK							Raw: 25
2	External Relief Dia	4.0 mm	Outside (2.2)		Inner				
3	External Relief Depth		7 mm		3 mm				
4	Inspection Done Before Hardening By (Name)								Raw:
5	Material Sent For Hardening By (Name)								Lark Porrace
6	Material Sent For Hardening On Date		19	4	25				

Inspected By (Sign) & Date

Raw: 19/4/15

Reviewed by (Engineer-CNC)

Manager-QA