



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.		9721	
2	Machined By			40/40
3	Pallet Die No.		9782 (4.0)mm	Dry Ho - handle ✓
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	500 mm OD Step - 491 mm	Step height - 17.5mm ✓
6	Inside Diameter	Drg. No.	420 mm	
7	Width of Pellet Die	Drg. No.	158 mm	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	(Tapping Ho of Holes - 8) Body
11	Tapping Operator		MIC Shah	Side) ✓
12	Tapping PCD		454 mm	
13	Tapping Hole Diameter		M20 check M20 Bolt)	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 18.5mm Tapping Depth - 16.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sanjiv 23/6/13	
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		
2	External Relief Dia	Ø 4.3	outside	hammer
3	External Relief Depth		4 mm (2-2)	MILL
4	Inspection Done Before Hardening By (Name)		Sanjiv	
5	Material Sent For Hardening By (Name)			
6	Material Sent For Hardening On Date		23	6
Inspected By (Sign) & Date			Sanjiv 23/6/13	

Reviewed by (Engineer-CNC)

Manager-QA