



Lark Engineering Company (India) Pvt. Ltd.

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

10565

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.		15773	
2	Machined By		VTK MIC Shop	45150
3	Pallet Die No.		15532 (4.0) mm	new
4	Die Category	Drg. No.	SCW	Day H- 1072
5	Out Side Diameter	Drg. No.	520 mm	OD Step - 491 mm
6	Inside Diameter	Drg. No.	420 mm	Step height = 16.5
7	Width of Pellet Die	Drg. No.	173 mm	
8	Grooves as per Drawing	Drg. No.	10 x 8.5 x 5 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Flapping Holes - 8 Bore (4)
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		MIC Shop	
12	Tapping PCD		455 mm	
13	Tapping Hole Diameter		Ø 3/4	check by Ø 3/4 Ball
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drilling Depth - 20.3 mm	Tapping Depth - 18.6 mm
16	Perpendicularity of Tapped Hole		OK	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

1/9/15

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 1-60

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	Ø 4.5	outside	inner			
3	External Relief Depth	13 mm		5 mm			
4	Inspection Done Before Hardening By (Name)						
5	Material Sent For Hardening By (Name)						
6	Material Sent For Hardening On Date		1	9	25		

Inspected By (Sign) & Date

1/9/15

Reviewed by (Engineer-CNC)

Manager-QA