



Lark Engineering Company (India) Pvt. Ltd.

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

10564

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.			
2	Machined By		15849	
3	Pallet Die No.		V7h MIC Sharp	521 RD
4	Die Category	Drg. No.	15886 (40) mm	Drg M-403 Rev
5	Out Side Diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	520 mm, OD Step-491 mm	Step height-17.5
7	Width of Pellet Die	Drg. No.	420 mm	
8	Grooves as per Drawing	Drg. No.	158 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	12 X 8 X 3 mm	
10	Drilling Area Surface Smoothness		OK	(Tapping Hole Holes-8)
11	Tapping Operator		MIC Sharp	
12	Tapping PCD		474 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-18.4 mm Tapping Depth-16.6 mm	
16	Perpendicularity of Tapped Hole		Yes	
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 - 60

1	Counter Sinking Depth & Finish	OK						
2	External Relief Dia	Ø 4.5	outside	12MM				
3	External Relief Depth	5	(2-2)	10				
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date		1	9	15			

Inspected By (Sign) & Date

1/9/15

Reviewed by (Engineer-CNC)

Manager-QA