



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.			
2	Machined By		9757	35/63/78
3	Pallet Die No.		V.T.L. M/C Shop	Dr. No. 18.039C
4	Die Category	Drg. No.	10409 (6.0) M	Rev: 00
5	Out Side Diameter	Drg. No.	M. Tomba	
6	Inside Diameter	Drg. No.	636 M / 632 M Step 00 - 63.5 M / 543 M	
7	Width of Pellet Die	Drg. No.	480 M / 489 M / 500 M	Step length 26 M
8	Grooves as per Drawing	Drg. No.	182 M	16.5 M
9	Fitting Sizes on CNC Plate	Drg. No.	37 x 12 x 8.9.5 M / 27 x 12 x 8.9.5 M	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		ok	
12	Tapping PCD		M/C Shop	Tapping No of holes: 4
13	Tapping Hole Diameter		540 M	
14	Tapping On Second Side	Half pitch of 1st side	M16 - Check by M16 Bolt	
15	Tapping Hole Depth		one side Tapping and	End side One Slot
16	Perpendicularity of Tapped Hole		Drill Depth: 28.4 M	Tapping Depth: 26.7
17	Visual Inspection Before Gun Drilling		yes	
Inspected By (Sign) & Date				
1	As per programme no.			1 Slot 28.1 M width 17 M Deep
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked		
4	Defective Holes (If Any)		ok	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish		ok	
2	External Relief Dia	6.5 M / 7.0 M	6.5 M All Lines / 7.0 M All Lines	Row 10
3	External Relief Depth		43 M / 15 M	
4	Inspection Done Before Hardening By (Name)			
5	Material Sent For Hardening By (Name)		Ravi	
6	Material Sent For Hardening On Date		Lark Fornere	
Inspected By (Sign) & Date			98 6 23	
			Ravi 98/6/23	

Reviewed by (Engineer-CNC)

Manager-QA