



Lark Engineering Co. (India)
 ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (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		10765	44/50
3	Pellet Die No.		V.T. L/M/C Shop	Qty. 18.0 - 403
4	Die category	Drg. No.	11337 (4.0)M	Rev 2.00 ✓
5	Outside diameter	Drg. No.	Senior	
6	Inside Diameter	Drg. No.	59mm / Step OD = 49mm, Step length = 17.5	
7	Width Of Pellet Die	Drg. No.	420.12M	
8	Grooves As Per Drawing	Drg. No.	158M	
9	Fitting Sizes on CNC Plate	Drg. No.	12x8x3M / 12x8x3M	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		OK	
12	Tapping PCD		M/C Shop	Tapping No of Holes = 8 Both Side
13	Tapping Hole Diameter		454M	
14	Tapping On Second Side	Half pitch of 1st side	0.34" Chack by 0.34" Bolt	
15	Tapping Hole Depth		OK	
16	Perpendicularity of Tapped Hole		Drill Depth = 19M Tapping Depth = 17M	
17	Visual Inspection Before Gun Drilling		yes	
Inspected By (Sign) & Date			OK	
			Ravi 11/12/13	
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	Rev 2.00
2	External Relief Dia.	4.5M	outside 0.2-2.8	
3	External Relief Depth		14M	Inner 6M
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		11/12/13	
Inspected By (Sign) & Date			Ravi 11/12/13	

Satyam
11/12/13

Reviewed by (Engineer (CNC))

Manager-QA