



**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.		10352	
2	Machined By		V.T. L n/c Shop	38/40 3195 Dry No. Task 3519
3	Pellet Die No.		10711 (4.0) H4	
4	Die category	Drg. No.	Senior	
5	Outside diameter	Drg. No.	499.8 H4 Step 00	490.8 H4 Step length 17.5
6	Inside Diameter	Drg. No.	480.12 H4	
7	Width Of Pellet Die	Drg. No.	158 H4	
8	Grooves As Per Drawing	Drg. No.	12x8x3 H4 / 18x8x3 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		454 H4 / 453.9 H4	Tapping No of 4.16, 8 Both Side
13	Tapping Hole Diameter		M20: Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19 H4 Tapping Depth 17 H4	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Ravi 4/12/13	
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	
<b>Note: Mark the defective holes/Missed holes with the help of Permanent Marker</b>				
1	Counter Sinking Depth & Finish	OK		Ravi do
2	External Relief Dia.	4.5 H4	outside / Inner	
3	External Relief Depth		6 H4 / 2 H4	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		4/12/13	
Inspected By (Sign) & Date			Ravi 4/12/13	

Reviewed by (Engineer (CNC))  
*[Signature]*

Manager-QA