



**Lark Engineering Co. (India)**  
ITI, Sasoli Road, YAMUNA NAGAR- 135 002 (Haryana)

Form No. CNC/QA/FM/02

Rev. No. 01

**Inprocess Inspection (Pellet Dies)**

Rev. Date 31.07.2013

S. No.	Check Parameter	Specification	Observations	Remarks
1	Work order no.		10808/	41/50
2	Machined By		V.T. L H/c Shop	Digres L.B.O. 70
3	Pellet Die No.		11498 (3.0) H/c	Reos 00
4	Die category	Drg. No.	M. Tomba	
5	Outside diameter	Drg. No.	700 H/c, Step OD = 700.8 H/c	Tapper = 4°
6	Inside Diameter	Drg. No.	601.5 H/c / ID Step = 600.1	Step length = 23.5
7	Width Of Pellet Die	Drg. No.	250 H/c	Under cut = 1.4 H/c
8	Grooves As Per Drawing	Drg. No.	24 x 5 x 8.5 H/c / 24 x 5 x 8.5	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		655 H/c	
13	Tapping Hole Diameter		M16 = Check by M16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 25.3 H/c	Tapping Depth = 23.9
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date Ravi 31/7/2013				
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:</b> Mark the defective holes/Missed holes with the help of Permanent Marker				
1	Counter Sinking Depth & Finish	ok		Reos = 41
2	External Relief Dia.	3.5 H/c	Outside 3.5   Inner	
3	External Relief Depth		1.6 H/c   1.0 H/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Roxane	
6	Material Sent For Hardening On Date		31/7/2013	
Inspected By (Sign) & Date Ravi 31/7/2013				

Satyam  
31/7/2013  
Reviewed by (Engineer (CNC))

Manager-QA