



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10522	
2	Machined By		V.T.L. N/C Shop	31/50 / 6355 Drg No. Lark 3310
3	Pallet Die No.		10834 (3.5) mm	
4	Die Category	Drg. No.	Extrusion Die	
5	Out Side Diameter	Drg. No.	6.20mm / Step OD 2.612mm / 6.11mm	Step length 17.5
6	Inside Diameter	Drg. No.	5.20.12mm	
7	Width of Pellet Die	Drg. No.	22.2mm	
8	Grooves as per Drawing	Drg. No.	13x8x5mm / 13x8x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		56.5mm	
13	Tapping Hole Diameter		M20 2 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 20.4mm / Tapping Depth 18.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 29/12/13

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

Counter 60°

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.0mm	Outside (3-3)		Inner		
3	External Relief Depth		22mm		19mm		
4	Inspection Done Before Hardening By (Name)				Ravi		
5	Material Sent For Hardening By (Name)				Lark Furnace		
6	Material Sent For Hardening On Date		29	12	23		

Inspected By (Sign) & Date

Ravi 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA