



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.		10909 ✓	30/50 ✓
2	Machined By		V.T.L. H/c Shop	Drg. No. Lark 6355/3310 ✓
3	Pallet Die No.		11088 (3.0) ✓	
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	6.20mm, Step CD = 6.12mm	Step length 19.5 ✓
6	Inside Diameter	Drg. No.	5.20mm ✓	
7	Width of Pellet Die	Drg. No.	2.20mm ✓	
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		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		56.5mm ✓	
13	Tapping Hole Diameter		M20, Check by M20 Ball ✓	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 20.4mm Tapping Depth 18.3mm ✓	
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								Low = 38
2	External Relief Dia	3.5mm	Outside (3-3)		Inner					
3	External Relief Depth		2.3mm		2.0mm					
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

Satyam 29/12/13

Reviewed by (Engineer-CNC)

Manager-QA