



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.		10908	
2	Machined By		V.T.L. HLC Shop	50/50
3	Pallet Die No.		11336 (8mm) M4	Drg. No. (I.E.C.I) 1376- Rev. 00
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	52mm Shop 00. 49mm	
6	Inside Diameter	Drg. No.	42.12mm	Step length 17.5
7	Width of Pellet Die	Drg. No.	158mm	
8	Grooves as per Drawing	Drg. No.	12+8x3mm / 12+8x3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		HLC Shop	
12	Tapping PCD		454mm	
13	Tapping Hole Diameter		M20.2 Check by M20 Roll	Tapping Dia of holes 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 19.8mm	Tapping Depth 17.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 30/12/13

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					Counter 60°
2	External Relief Dia	8.5mm	outside (2-2)	Inner			Raw 12
3	External Relief Depth		4mm	Mill			
4	Inspection Done Before Hardening By (Name)			Ravi			
5	Material Sent For Hardening By (Name)			Lark Furnace			
6	Material Sent For Hardening On Date		30	12	13		

Inspected By (Sign) & Date

Ravi 30/12/13

Reviewed by (Engineer-CNC)

Manager-QA