



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.		10933	
2	Machined By		V.T.L. M/c Shop	40/65 ✓
3	Pallet Die No.		11492 (10.0) M/c	Drg. No. S.O. 788
4	Die Category	Drg. No.	M. Jumbo ✓	Revol ✓
5	Out Side Diameter	Drg. No.	678 M/c	
6	Inside Diameter	Drg. No.	Step 60, 693 M/c	Tappers 3°
7	Width of Pellet Die	Drg. No.	548.12 M/c	Step lengths 23 M/c
8	Grooves as per Drawing	Drg. No.	195 M/c	Under cut = 2.30 M/c
9	Fitting Sizes on CNC Plate	Drg. No.	31x2x2 M/c 31x2x2 M/c (5x8) M/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step 1 M/c Deep Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619 M/c	Tapping No
13	Tapping Hole Diameter		M16	of Hole 2
14	Tapping On Second Side	Half pitch of 1st side	ok	Both Side
15	Tapping Hole Depth		Drill Depth 39.4 M/c	Tapping Depth 32 M/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 30/7/13

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	ok
4	Defective Holes (If Any)		ok

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

1	Counter Sinking Depth & Finish	ok					Counters 60°
2	External Relief Dia	11.0 M/c	All Rows				Rev 18
3	External Relief Depth		25 M/c				
4	Inspection Done Before Hardening By (Name)		Ravi				
5	Material Sent For Hardening By (Name)		Lark Purvare				
	Material Sent For Hardening On Date		20	12	25		

Inspected By (Sign) & Date

Ravi 30/7/13

Reviewed by (Engineer-CNC)

Manager-QA