



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.		11201	34/45
2	Machined By		V.T.L. n/c Step	Drilled 15.0 ± 0.36
3	Pallet Die No.		11208 (2.8) n/c	Rev. 00
4	Die Category	Drg. No.	H. Tombo	
5	Out Side Diameter	Drg. No.	690 n/c Step 00. 692.8 n/c	⑤ Tappers 12
6	Inside Diameter	Drg. No.	600.12 n/c	Step length 30 n/c
7	Width of Pellet Die	Drg. No.	222 n/c	Under cut 1.4 n/c
8	Grooves as per Drawing	Drg. No.	12 x 8 x 7 n/c / 12 x 8 x 7 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		n/c Step	Tapping dia of Holes 12 Both Side
12	Tapping PCD		640 n/c	
13	Tapping Hole Diameter		M20 Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 21.4 n/c	Tapping Depth 18.8 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/2/14

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	3.1 n/c	outside (3-3)		Inner		Rev 2 41
3	External Relief Depth		17 n/c		11 n/c		
4	Inspection Done Before Hardening By (Name)						Ravi
5	Material Sent For Hardening By (Name)						Lark Furnace
6	Material Sent For Hardening On Date			3	2	24	

Inspected By (Sign) & Date

Ravi 31/2/14

Reviewed by (Engineer-CNC)

Manager-QA