



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.		11128	52/55
2	Machined By		V. TIL. H/C Shop	Drg No. (S.9. 412
3	Pallet Die No.		11634 (4.0) H/C	Rev. 00
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	710 H/C Step OD = 692.8 H/C	Step length 2.5 mm
6	Inside Diameter	Drg. No.	680.12 H/C	Tapper 12
7	Width of Pellet Die	Drg. No.	222 H/C	
8	Grooves as per Drawing	Drg. No.	14x8x7 H/C / 14x8x7 H/C	
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
12	Tapping PCD		640 H/C	Both Side
13	Tapping Hole Diameter		H2 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 22.8 H/C Tapping Depth 20.2	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Pass: 31/8/14

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

Count 012 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5 H/C	Outside (3-3)		Inner				
3	External Relief Depth		11 H/C		3 H/C				
4	Inspection Done Before Hardening By (Name)								
5	Material Sent For Hardening By (Name)								
6	Material Sent For Hardening On Date			3	8	24			

Inspected By (Sign) & Date

Pass: 31/8/14

Reviewed by (Engineer-CNC)

Manager-QA

Reviewed by (Engineer-CNC)

Manager-QA