



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

Inprocess Inspection (Pellet Dies)

Rev. Date 31-07-2013

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		11282	43/52
2	Machined By		V. T. L. N/C Shop	Dry No. 6.8.0. 314
3	Pallet Die No.		11395 (4.0)mm	Rev. 00
4	Die Category	Drg. No.	338TD	
5	Out Side Diameter	Drg. No.	622.8mm Step 002 Tapper 12° Steplength	18
6	Inside Diameter	Drg. No.	520.12mm / 520.14mm	14
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	13x5x5mm / 13x5x5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		N/C Shop	Tapping No. of holes = 12 Both Side
12	Tapping PCD		565mm	
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 91mm Tapping Depth 19mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 21/7/14

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

Counter: 60°

1	Counter Sinking Depth & Finish	OK							
2	External Relief Dia	4.5mm	Outside (3-3)		Inner				
3	External Relief Depth		13mm		9mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		21	2	24				

Inspected By (Sign) & Date

Ravi 21/7/14

21/7/14

Reviewed by (Engineer-CNC)

Manager-QA