



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.		11334/	35/50/
2	Machined By		N.T.L. H/c Shop	6355 Dy. H/c Lark 3510
3	Pallet Die No.		11090 (6.0) H/c	
4	Die Category	Drg. No.	Ext. & wide	
5	Out Side Diameter	Drg. No.	620 H/c, Step 002 618 H/c	Step length 19.4
6	Inside Diameter	Drg. No.	520.12 H/c	
7	Width of Pellet Die	Drg. No.	229 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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 Both Side
12	Tapping PCD		565 H/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 H/c	Tapping Depth 18.7
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date *Ravi 22/8/14*

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

1	Counter Sinking Depth & Finish	OK						Counter 600 Rows 22
2	External Relief Dia	6.5 H/c	Outside (3-3)	Inner				
3	External Relief Depth		20 H/c	15 H/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		22	2	24			

Inspected By (Sign) & Date *Ravi 22/8/14*

Satyam
22/8/14
Reviewed by (Engineer-CNC)

Manager-QA