



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.		11275	33/43/76
2	Machined By		V. T.I. n/c Shop	Dry No. 1.2.02 382
3	Pallet Die No.		11507 (6.0) n/c	Rev 2.00
4	Die Category	Drg. No.	SSSTO	
5	Out Side Diameter	Drg. No.	660mm, Step 002 683mm	Step length 18mm
6	Inside Diameter	Drg. No.	52.12 mm	Tapper 12
7	Width of Pellet Die	Drg. No.	186 mm	
8	Grooves as per Drawing	Drg. No.	10x10x7mm / 10x10x7mm	
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		565 mm	
13	Tapping Hole Diameter		M2 = Check by M2 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21mm Tapping Depth = 18mm	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 23/7/13

1	As per programme no.			2 Slot 25mm width Gun Reek Both Side
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 = 600

1	Counter Sinking Depth & Finish	ok							Ravi 23/7/13
2	External Relief Dia	6.5mm / 7.0mm	6.5mm All Rows	7.0mm All Rows					
3	External Relief Depth		37 mm	27 mm					
4	Inspection Done Before Hardening By (Name)								Ravi
5	Material Sent For Hardening By (Name)								Lark Furnace
6	Material Sent For Hardening On Date		23	24					

Inspected By (Sign) & Date

Ravi 23/7/13

Reviewed by (Engineer-CNC)

Manager-QA