

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.		12437	28/45
2	Machined By		V.T.L M/c Shop	Drg No- LSD 615
3	Pallet Die No.		11854 (3.0mm)	(Rev00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	610mm Step up- 623.7mm	Step length- 20mm
6	Inside Diameter	Drg. No.	520.12mm	Under cut- 6.3mm
7	Width of Pellet Die	Drg. No.	186mm	Taper- 12°
8	Grooves as per Drawing	Drg. No.	13 X 8 X 3mm / 13 X 8 X 3mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	[Tapping No. of Holes 12 Both side]
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
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- 20.4mm Tapping Depth- 18.5mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date Ramanpreet Singh 20/08/14

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							Row- 30
2	External Relief Dia	3.5mm	outside (3-3)	Inner					
3	External Relief Depth		22mm	19mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		20	08	24				

Inspected By (Sign) & Date Ramanpreet Singh 20/08/14

Satya
20/8/14

Reviewed by (Engineer-CNC)

Manager-QA