



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.		1P738	35/55
2	Machined By		V.T.L M/c Shop	Drg No - LSD 666
3	Pallet Die No.		1P205 (40mm)	(Rev 00)
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	710mm Step 00 - 693mm	Step Length - 20mm
6	Inside Diameter	Drg. No.	600.12mm	Tabber - 12
7	Width of Pellet Die	Drg. No.	222mm	
8	Grooves as per Drawing	Drg. No.	1P X 10 X 7.5mm / 1P X 10 X 7.5mm	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Tapping No. of Holes 1P Both Side]
11	Tapping Operator		M/c Shop	
12	Tapping PCD		670mm	
13	Tapping Hole Diameter		M 20 check by M 20 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 28/08/14

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° Row-

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	4.5mm	outside (3-3)	Inner			
3	External Relief Depth		27mm	20mm			
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		28	08	24		

Inspected By (Sign) & Date

Ramanpreet Singh 28/08/14

28/8/14

Reviewed by (Engineer-CNC)

Manager-QA