



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.		12696 ✓	17/66 ✓
2	Machined By		V.T.L M/c Shop	Drg No- 25D 609
3	Pallet Die No.		12953 (6.0mm)	(Revof)
4	Die Category	Drg. No.	M. Jumbo	groove-413mm
5	Out Side Diameter	Drg. No.	680.1mm	Step od- 693mm
6	Inside Diameter	Drg. No.	548.12mm	Step Length- 3mm
7	Width of Pellet Die	Drg. No.	195mm	Taper- 8°
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	Under cut- 2.5mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	4 X 8mm ✓
10	Drilling Area Surface Smoothness		ok	Tapping No. of Holes 4 Both Side
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm ✓	
13	Tapping Hole Diameter		M16 check by M16 Bolt	Face Side Step
14	Tapping On Second Side	Half pitch of 1st side	ok	2mm Deep
15	Tapping Hole Depth		Drill Depth- 34.4mm Tapping Depth- 31.8mm	Both Side
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 29/08/14

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

1	Counter Sinking Depth & Finish	ok						Counter-30°
2	External Relief Dia	7.5mm	ADD Rows					Row-12
3	External Relief Depth		47mm					
4	Inspection Done Before Hardening By (Name)		Ramanpreet Singh					
5	Material Sent For Hardening By (Name)		Lark Force					
6	Material Sent For Hardening On Date		29	08	24			

Inspected By (Sign) & Date

Ramanpreet Singh 29/08/14

Satya 29/8/14

Reviewed by (Engineer-CNC)

Manager-QA