

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.		19751	45/56
2	Machined By		V.T.L M/c Shop	Drg No - LSD 1138
3	Pallet Die No.		12074(8.0mm)	(REV00)
4	Die Category	Drg. No.	SSSTD	
5	Out Side Diameter	Drg. No.	630 H-H, Step OD 612 H-H	Step length - 19.5mm
6	Inside Diameter	Drg. No.	518.1 H-H, one side 10 Step = 520.12mm	
7	Width of Pellet Die	Drg. No.	186mm	
8	Grooves as per Drawing	Drg. No.	14x6x3 H-H 14x6x3 H-H	
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		5/8 Check by 5/8 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 05/09/14	
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-14
2	External Relief Dia	8.5mm	Outside (3-3) Inner	
3	External Relief Depth		15mm, 11mm	
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		05 09 14	
Inspected By (Sign) & Date			Ramanpreet Singh 05/09/14	

Reviewed by (Engineer-CNC)

Manager-QA