



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.		12796	55/66
2	Machined By		V.T.L M/c Shop	Dwg No-LSD 609
3	Pallet Die No.		13281 (8.0mm)	(REV 01)
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	680.7 ^{mm} Step 00 - 693 ^{mm}	Step Length - 31mm
6	Inside Diameter	Drg. No.	548.12 ^{mm}	Taper - 8°
7	Width of Pellet Die	Drg. No.	195mm	Under cut - 2.5mm
8	Grooves as per Drawing	Drg. No.	32 X 7 X 8mm / 32 X 7 X 8mm	4 X 8mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Tapping No. of Holes 4 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		619mm	
13	Tapping Hole Diameter		M16 Check by M16 Bolt	Face Side step 2mm
14	Tapping On Second Side	Half pitch of 1st side	ok	Deep Both Side
15	Tapping Hole Depth		Drill Depth - 34.8mm Tapping Depth - 31.8mm	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ramanpreet Singh 16/09/14

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 - 30° Row - 10

1	Counter Sinking Depth & Finish	ok					
2	External Relief Dia	9.0mm	All Rows				
3	External Relief Depth		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		16	09	14		

Inspected By (Sign) & Date

Ramanpreet Singh 16/09/14

Reviewed by (Engineer-CNC)

Manager-QA