



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)

8603

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13299	42/50 ✓
2	Machined By		V.T.L M/c Shop	Drg No - LSD/1184
3	Pallet Die No.		13457 (6.0mm)	(Rev 00)
4	Die Category	Drg. No.	Senior	
5	Out Side Diameter	Drg. No.	520mm ✓	Step length - 17.5mm ✓
6	Inside Diameter	Drg. No.	420.12mm ✓	
7	Width of Pellet Die	Drg. No.	158mm ✓	
8	Grooves as per Drawing	Drg. No.	12 x 8 x 3mm / 12 x 8 x 3mm ✓	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Tapping No. of Holes 8 Both Side ✓
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/c Shop	
12	Tapping PCD		456mm ✓	
13	Tapping Hole Diameter		3/4" check by 3/4" Bolt ✓	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth - 18.4mm Tapping Depth - 16.5mm ✓	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ramanjeet Singh 23/11/14

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 800

1	Counter Sinking Depth & Finish	OK				
2	External Relief Dia	6.5mm	outside (P-7)	Inner		
3	External Relief Depth		14mm	8mm		
4	Inspection Done Before Hardening By (Name)		Ramanjeet Singh			
5	Material Sent For Hardening By (Name)		Lark Furnace			
6	Material Sent For Hardening On Date		P3	11	P4	

Inspected By (Sign) & Date

Ramanjeet Singh 23/11/14

Signature 23/11/14

Reviewed by (Engineer-CNC)

Manager-QA