



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.		13238	60/55.5
2	Machined By		V. T. L. n/c Shop	Drg. No. 120-90
3	Pallet Die No.		14073 (12.0) n/c	Row 03
4	Die Category	Drg. No.	83370	
5	Out Side Diameter	Drg. No.	639.7 n/c, Step 00-652.3 n/c	Tappers 3"
6	Inside Diameter	Drg. No.	508.8 n/c (10 Step - 529.7/522.3 n/c)	Step 10.9/12.3 n/c
7	Width of Pellet Die	Drg. No.	175 n/c	
8	Grooves as per Drawing	Drg. No.	30 x 21 x 7.25 n/c / 9 x 2.5 n/c	Face Side
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Step 20.5 n/c
10	Drilling Area Surface Smoothness		ok	Back
11	Tapping Operator		n/c Shop	Tapping No.
12	Tapping PCD		574 n/c	of holes: 4
13	Tapping Hole Diameter		H16, Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and Third Side 4.50	
15	Tapping Hole Depth		Drill Depth 30.3 n/c	Tapping Depth 28.6 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi: 14/12/14	
1	As per programme no.			51.5 n/c long
2	Gun Drilling Work Completed On			28.1 n/c width
3	Hole Finish In Gun Drilling	Marked	ok	15 n/c Deep
4	Defective Holes (If Any)		No	
Note : Mark the defective holes/Missed holes with the help of Permanent Marker				Counters 60
1	Counter Sinking Depth & Finish	ok		Row 25
2	External Relief Dia	12.5 n/c	All Rows	
3	External Relief Depth		5.5 n/c	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		14 12 24	
Inspected By (Sign) & Date			Ravi: 14/12/14	

Reviewed by (Engineer-CNC)

Manager-QA