



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)

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13508 ✓	60/65.5 ✓
2	Machined By		V.T.L. n/c Shop	Dy. N. 2-20, 90 ✓
3	Pallet Die No.		14166(12.0) n/c ✓	Rev=03 ✓
4	Die Category	Drg. No.	38870	
5	Out Side Diameter	Drg. No.	639.6 n/c, Step 00 = 652.2 n/c	Tabber = B ✓
6	Inside Diameter	Drg. No.	508.8 n/c (10 Step = 539.7 n/c / 523.28 n/c)	
7	Width of Pellet Die	Drg. No.	175.1 n/c	Step length = 32 n/c ✓
8	Grooves as per Drawing	Drg. No.	30 x 21 x 7.25 n/c / 9 x 25 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side step 0.5 n/c Deep ✓
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	Tapping no. of holes = 4 ✓
12	Tapping PCD		574 n/c	
13	Tapping Hole Diameter		M/G. Check by M/G Bolt	
14	Tapping On Second Side	Half pitch of 1st side	one side Tapping and 2nd side 4 slot	
15	Tapping Hole Depth		Drill Depth = 30.3 n/c Tapping Depth = 28.7 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 18/12/14	4 slot
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				
1	Counter Sinking Depth & Finish	ok		Counter = 60° Row = 5
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		18 12 24	
Inspected By (Sign) & Date			Ravi 18/12/14	

Reviewed by (Engineer-CNC)

Manager-QA