



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.		13644	57100
2	Machined By		V.T.L. H/c Shop	Dy. H. L.S.D = 330
3	Pallet Die No.		13932 (10.0) H/c	Rev: 08
4	Die Category	Drg. No.	M. Tombo	
5	Out Side Diameter	Drg. No.	680.1 H/c, Step OD = 693.1 H/c	Tapper = 8°
6	Inside Diameter	Drg. No.	546.12 H/c (Box = 548.12 H/c)	Step length = 31 H/c
7	Width of Pellet Die	Drg. No.	195 H/c	Under cut = 2.8 H/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 H/c 32 x 7 x 9.1 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Race Side Step 2 H/c Dash Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 H/c	Tapping No of holes 2 Both Side
13	Tapping Hole Diameter		M16 Check by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 33.2 H/c	Tapping Depth = 31.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/7/14

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								
2	External Relief Dia	11.0 H/c	All Rows							Row = 8
3	External Relief Depth		9 H/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		28	12	24					

Inspected By (Sign) & Date

Ravi 28/7/14

Reviewed by (Engineer-CNC)

Manager-QA