



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.		13590	35/40/66
2	Machined By		N.T.L. n/c Shop	Dy. No. L302609
3	Pallet Die No.		13931 (6.0) n/c	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 n/c Step 00. 692.8 n/c Tapper 8°	
6	Inside Diameter	Drg. No.	546.2 n/c (Bot - 548.12 n/c)	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Undercut 2.5 n/c
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 n/c 32.7 x 9.2 n/c (4.8) n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step
10	Drilling Area Surface Smoothness		ok	2 n/c Deep
11	Tapping Operator		n/c Shop	Back Side
12	Tapping PCD		619 n/c	Tapping dia
13	Tapping Hole Diameter		M16 - Check by M16 Bolt	of holes 2 &
14	Tapping On Second Side	Half pitch of 1st side	ok	Back Side
15	Tapping Hole Depth		Drill Depth 33.4 n/c Tapping Depth 31.5 n/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 18/12/14

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

1	Counter Sinking Depth & Finish	ok						Counter Bo
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c A1	Rows 2	31 n/c			Ravi 12
3	External Relief Depth		7.0 n/c A1	Rows 2	26 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