



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.		13808	55/55
2	Machined By		V.T.L. H/c Shop	Drg No. 1302407
3	Pallet Die No.		14096 (5.0) H/c	Rev 2.00
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	709.8 H/c (M) Step OD = 693 H/c	Tapper 12°
6	Inside Diameter	Drg. No.	600.12 H/c / 600.14 H/c (M)	Step length 8 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	12x8x7 H/c / 12x8x7 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		640 H/c	
13	Tapping Hole Diameter		H20. Check by H20 B-11	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 20.2 H/c	Tapping Depth 18 H/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Sasi 21/25	
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 = 60
2	External Relief Dia	5.5 H/c	Outside (3.3)	Lower 27
3	External Relief Depth		5 H/c	Inner Mill
4	Inspection Done Before Hardening By (Name)			Ravi
5	Material Sent For Hardening By (Name)			Lark Forncore
6	Material Sent For Hardening On Date		7	1 25
Inspected By (Sign) & Date			Sasi 21/25	

Reviewed by (Engineer-CNC)

Manager-QA