



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.		13747	36/45/50
2	Machined By		V.T.L. H/c Shop	Dy No. 13.0.70
3	Pallet Die No.		12974(4.0) H/c	Rec 200
4	Die Category	Drg. No.	H-1000	
5	Out Side Diameter	Drg. No.	700 H/c Step 002 70.8 H/c	Tapper 4"
6	Inside Diameter	Drg. No.	600.12 H/c / 601.5 H/c (Bore 601.5)	Step length 93.5
7	Width of Pellet Die	Drg. No.	250 H/c	Under cut = 1.4 H/c
8	Grooves as per Drawing	Drg. No.	24 x 5 x 8.5 H/c / 24 x 5 x 9 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Discuss with Sachin Sir
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		H/c Shop	Tapping H/c of Holes 12 Rota Side
12	Tapping PCD		655 H/c	
13	Tapping Hole Diameter		MIG - Check by MIG Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 24.3 H/c	Tapping Depth 22.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 31/25

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 - 2 Hole Closed

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter 60-
Row 34

1	Counter Sinking Depth & Finish	ok				
2	External Relief Dia	4.5 H/c / 5.0 H/c	4.5 H/c	All Rows 2 14 H/c		
3	External Relief Depth		5.0 H/c	All Rows 2 5 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		6	1	25	

Inspected By (Sign) & Date

Ravi 31/25

Satyam 31/25

Reviewed by (Engineer-CNC)

Manager-QA