



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)

8948

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13396	27/65
2	Machined By		V.T. L n/c Shop	Dr. No. 1.80.693
3	Pallet Die No.		14202 14202 (B.3) n/c	Rev. 00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 n/c	Step 00, 823 n/c
6	Inside Diameter	Drg. No.	700.12 n/c	Tapper 4"
7	Width of Pellet Die	Drg. No.	324 n/c	Step length 33 n/c
8	Grooves as per Drawing	Drg. No.	30 x 8 x 8.5 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	30 x 8 x 8.5 n/c	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		760 n/c	
13	Tapping Hole Diameter		M22	Check by M22 Bolt
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 362 n/c	Tapping Depth 34.5
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 8/12/15

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 - 4 Hole Colused

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	4.3 n/c	outside (B-3)		Inner				
3	External Relief Depth		42 n/c		38 n/c				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Romace				
6	Material Sent For Hardening On Date		8	1	25				

Inspected By (Sign) & Date

Ravi 8/12/15

Ravi 8/12/15

Reviewed by (Engineer-CNC)

Manager-QA