



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.		13882 ✓	26/34/105 ✓
2	Machined By		V.T.L. n/c Shop	Dy No. 13.06.190
3	Pallet Die No.		14225 (6.0) n/c	Re-use
4	Die Category	Drg. No.	S. Jumbo	✓
5	Out Side Diameter	Drg. No.	1059.7 n/c ✓	Step OD, 1077 n/c Tapper 8°
6	Inside Diameter	Drg. No.	848.12 n/c 846.12 n/c Bor 85 n/c	Step length 40 n/c
7	Width of Pellet Die	Drg. No.	266 n/c	Under cut 3.5 n/c
8	Grooves as per Drawing	Drg. No.	45 x 8 x 9.2 n/c 45 x 8 x 10.1 n/c	(8-8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face side step
10	Drilling Area Surface Smoothness		ok	2 n/c Ramp Both Side
11	Tapping Operator		n/c Shop	Tapping No
12	Tapping PCD		952 n/c	of holes 2
13	Tapping Hole Diameter		n/c	Both Side
14	Tapping On Second Side	Half pitch of 1st side	n/c	Check by n/c Bolt
15	Tapping Hole Depth		Drill Depth 42.3 n/c	Tapping Depth 40 n/c
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 20/12/5

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 2 30°
2	External Relief Dia	7.0 n/c 7.5 n/c	7.0 n/c	All Rows 2 79 n/c			Row 16
3	External Relief Depth	/	7.5 n/c	All Rows 2 71 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		20	1	25		

Inspected By (Sign) & Date

Ravi 20/12/5

Reviewed by (Engineer-CNC)

Manager-QA