



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.		14017 ✓	57/66
2	Machined By		V.T.L. H/c Shop	Dy No. 120370
3	Pallet Die No.		14015 (10.0) mm	Rev=08
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm ✓ Step OD 690.8 mm	Tappers 8"
6	Inside Diameter	Drg. No.	546.12 mm (Box = 548.12 mm)	Step length 21 mm
7	Width of Pellet Die	Drg. No.	195 mm ✓	Under note 2.8 mm
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.1 mm (32 x 7 x 9.1 mm)	(4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Face side step 3 mm Deep Back side]
11	Tapping Operator		H/c Shop	
12	Tapping PCD		619 mm	[Tapping No. of 4-12 x 3 Back side]
13	Tapping Hole Diameter		HIG 2 Check by HIG Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 mm	Tapping Depth 31.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 28/12/13

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	11.0 mm	All Rows					Row 8
3	External Relief Depth		9 mm					
4	Inspection Done Before Hardening By (Name)		Ravi					
5	Material Sent For Hardening By (Name)		Lark Pornee					
6	Material Sent For Hardening On Date		28	1	25			

Inspected By (Sign) & Date

Ravi 28/12/13

Reviewed by (Engineer-CNC)

Manager-QA