



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.		10113 to 10187	25/35/66
2	Machined By		N.T.L. H/c Shop	28/38/66
3	Pallet Die No.		10755 (G.O) H/c	Drg No. L.S.D. 69
4	Die Category	Drg. No.	N. Jumbo	Rev 201
5	Out Side Diameter	Drg. No.	680.69 H/c	Step OD: 693 H/c
6	Inside Diameter	Drg. No.	548.12 H/c	Step length: 31
7	Width of Pellet Die	Drg. No.	195 H/c	Tapper - 3°
8	Grooves as per Drawing	Drg. No.	32 x 7 x 8 H/c	Ud ext cut = 2.5 H/c
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 8 H/c	(4 x 8) H/c
10	Drilling Area Surface Smoothness		ok	Face side step 2 H/c
11	Tapping Operator		H/c Shop	Deep Both side
12	Tapping PCD		619 H/c	Tapping No of Holes = 4
13	Tapping Hole Diameter		M16 Contact by M16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 334 H/c	Tapping Depth 31.9
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 11/12/13

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						
2	External Relief Dia	6.5 H/c	7.0 H/c	1st Pac All Cms	2.0 H/c	6.5 H/c	7.0 H/c	All Cms
3	External Relief Depth	4.1 H/c	3.1 H/c	1st Pac All Cms	3.8 H/c	2.8 H/c		
4	Inspection Done Before Hardening By (Name)							
5	Material Sent For Hardening By (Name)							
6	Material Sent For Hardening On Date							

Inspected By (Sign) & Date

Ravi 11/12/13

Reviewed by (Engineer-CNC)

Manager-QA