



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.			
2	Machined By		14186 / V.T.L n/c Shop	34/50 / Dykt. 1.8.02-119
3	Pallet Die No.		13557 (2.8) mm	Rev. 100
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	700 mm, Step 00, 692 mm	Step length 12.5
6	Inside Diameter	Drg. No.	600.12 mm	
7	Width of Pellet Die	Drg. No.	222 mm	
8	Grooves as per Drawing	Drg. No.		
9	Fitting Sizes on CNC Plate	Drg. No.	12.5 x 8 x 7 mm / 12.5 x 8 x 7 mm	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		645 mm	
13	Tapping Hole Diameter		H20 = Check by H20 Bolt	Tapping No of 4-tee, 12 Back Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 22.3 mm	Tapping Depth. 20.0 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/13

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 + G ^o
2	External Relief Dia	3.3 mm	outside (3-3)		Inner			Rev. 40
3	External Relief Depth		22 mm		16 mm			
4	Inspection Done Before Hardening By (Name)							Ravi
5	Material Sent For Hardening By (Name)							Lark Furnace
6	Material Sent For Hardening On Date		27	2	25			

Inspected By (Sign) & Date

Ravi 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA