



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.		14164	55/100
2	Machined By		V.T.L. n/a Shop	Diagonal Size 9743
3	Pallet Die No.		14269 (3.0) n/a	Rows = 03
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1051 n/a	
6	Inside Diameter	Drg. No.	Step 60, 1041.3 n/a	Tappers 4° Step
7	Width of Pellet Die	Drg. No.	851.12 n/a (CID Step length 17 n/a)	Tappers 15°
8	Grooves as per Drawing	Drg. No.	251 n/a	
9	Fitting Sizes on CNC Plate	Drg. No.	50x11x10.2 n/a 50x11x10.2 n/a	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/a Shop	
12	Tapping PCD		958 n/a	Tapping No of Holes = 24
13	Tapping Hole Diameter		M30 - Crack by M30 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 43.5 n/a	Tapping Depth = 41 n/a
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 26/7/13

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 = 30°
2	External Relief Dia	9.0 n/a		All Rows				Rows = 12
3	External Relief Depth			45 n/a				
4	Inspection Done Before Hardening By (Name)			Ravi				
5	Material Sent For Hardening By (Name)			Lark Furnace				
6	Material Sent For Hardening On Date		26	2	25			

Inspected By (Sign) & Date

Ravi 26/7/13

Satish 26/7/13

Reviewed by (Engineer-CNC)

Manager-QA