



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

99.90

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14010	57/66
2	Machined By		V.T.L n/c Shop	Dy. n/c 12.0.30
3	Pallet Die No.		14025 (10.0) n/c	Rev. ok
4	Die Category	Drg. No.	H. Jumbo	
5	Out Side Diameter	Drg. No.	680.1 n/c, Step 002 693 n/c	Tappere 8
6	Inside Diameter	Drg. No.	546.12 n/c (Bor. 548.4 n/c)	Step length 31 n/c
7	Width of Pellet Die	Drg. No.	195 n/c	Wd cut = 2.8 n/c
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 n/c 32 x 7 x 9.2 n/c	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side Step 2 n/c Deep Both Side Tapping n/c of Holes 2 Both Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 n/c	
13	Tapping Hole Diameter		H16, Check by n/c Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.2 n/c	Tapping Depth 31.5 n/c
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 8
2	External Relief Dia	H.0 n/c	All fows	
3	External Relief Depth	"	9 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		27 2 25	
Inspected By (Sign) & Date			Ravi 27/7/13	

Reviewed by (Engineer-CNC)

Manager-QA