



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.		14010	57/SS
2	Machined By		V.T.C. M/C Shop	Drilling U.O. 230
3	Pallet Die No.		14027 (10.0) M/C	Revs 08
4	Die Category	Drg. No.	M. Turnbo	
5	Out Side Diameter	Drg. No.	680.1 M/C Step 002 699 M/C	Tapper 8"
6	Inside Diameter	Drg. No.	546.12 M/C (Bar = 548.4 M/C)	Step length 31 M/C
7	Width of Pellet Die	Drg. No.	195 M/C	Under cut = 2.8 M/C
8	Grooves as per Drawing	Drg. No.	32 x 7 x 9.2 M/C 32 x 7 x 9.2 M/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Race Side of Tap 2 M/C Rasp Back Side
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		619 M/M	Tapping Holes of holes of Back Side
13	Tapping Hole Diameter		M/C = Check by M/C Ball	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 33.3 M/M	Tapping Depth 31.6
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

Counters 8

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	11.0 M/M	All holes						
3	External Relief Depth		9 M/M						
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	7	25				

Inspected By (Sign) & Date

Ravi 27/7/13

Satyajit 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA