



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)

9517

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		14403 ✓	40/50/66
2	Machined By		V. T. L. N/C Shop	Drill. 1.8.0
3	Pallet Die No.		14740 (B-0) H/H	Rev 03
4	Die Category	Drg. No.	N. Tumbo	
5	Out Side Diameter	Drg. No.	680.7 H/H, Step 00. 393 H/H	Tapped 8
6	Inside Diameter	Drg. No.	546.12 H/H (Box: 548.4 H/H)	Step length 31 H/H
7	Width of Pellet Die	Drg. No.	195 H/H	center cut = 2.5 H/H
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 H/H 32.7 x 9.2 H/H (4 x 2) H/H	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face Side
10	Drilling Area Surface Smoothness		OK	Step 2 H/H Deep
11	Tapping Operator		N/C Shop	Both Side
12	Tapping PCD		319 H/H	Tapping H/H
13	Tapping Hole Diameter		M16 Check by M16 Bolt	of Holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 33.2 H/H	Tapping Depth 3.8
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sav: 21/7/15	
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	Count on 30	
2	External Relief Dia	6.5 H/H 1.3 H/H	6.5 H/H All Rows 2 28 H/H	Row = 12
3	External Relief Depth		7.0 H/H All Rows 2 16 H/H	
4	Inspection Done Before Hardening By (Name)		Sav	
5	Material Sent For Hardening By (Name)		Lark Burner	
6	Material Sent For Hardening On Date		2	4 25
Inspected By (Sign) & Date			Sav: 21/7/15	

Reviewed by (Engineer-CNC)

Manager-QA