



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		14428 ✓	28/08/13
3	Pallet Die No.		V.T.L. n/c Shop	Drill 12.0 609
4	Die Category	Drg. No.	14743 (G.O) n/c	Rev 03
5	Out Side Diameter	Drg. No.	M. Jura bo	
6	Inside Diameter	Drg. No.	680.7 mm Step 00. 693 mm	Tap hole 8°
7	Width of Pellet Die	Drg. No.	546.12 mm (Box 588.4 mm)	Step length 31 mm
8	Grooves as per Drawing	Drg. No.	195 mm	Width cut 2.5 mm
9	Fitting Sizes on CNC Plate	Drg. No.	32 x 7 x 9.2 mm / 32 x 7 x 9.2 mm	(4 x 8)
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		n/c Shop	2 mm Groove Bottom
12	Tapping PCD		619 mm	Side
13	Tapping Hole Diameter		H16.2 Check by H16 Bolt	Tapping No. of holes 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Bottom Side
15	Tapping Hole Depth		Drill Depth 33.2 mm	Tapping Depth 31.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 28/8/13

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	6.5 mm / 1.0 mm	6.5 mm	All Rows 2	38 mm					Rev 12
3	External Relief Depth		7.0 mm	All Rows 2	28 mm					
4	Inspection Done Before Hardening By (Name)									Ravi
5	Material Sent For Hardening By (Name)									Lark Romance
6	Material Sent For Hardening On Date		28	3	25					

Inspected By (Sign) & Date

Ravi 28/8/13

Reviewed by (Engineer-CNC)

Manager-QA