



Lark Engineering Company (India) Pvt. Ltd.

I.T.I. Sasouli Road, Yamuna Nagar - 135 001 (Haryana)

9516

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		14560	57/66
3	Pallet Die No.		V.T.L H/C Shop	Dr. No. 12.0.32
4	Die Category	Drg. No.	14769 (10.0) H/C	Rev 2.08
5	Out Side Diameter	Drg. No.	M. Jumbo	
6	Inside Diameter	Drg. No.	680.1 H/C	Step 00.693 H/C
7	Width of Pellet Die	Drg. No.	546.12 H/C (Bar = 548.1)	Step length 31 H/C
8	Grooves as per Drawing	Drg. No.	195 H/C	Lock cut = 2.8 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.1 H/C	32.7 x 9.1 H/C (4 x 8) H/C
10	Drilling Area Surface Smoothness		ok	Face Side
11	Tapping Operator		H/C Shop	Step 2 H/C Shop
12	Tapping PCD		619 H/C	Both Side
13	Tapping Hole Diameter		H/C = Check by H/C Bolt	Tapping No. 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/C	Tapping Depth 31.6
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Rajinder 25	
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		Countersink 8
2	External Relief Dia	11.0 H/C	All Rows	
3	External Relief Depth		9 H/C	
4	Inspection Done Before Hardening By (Name)		Raj!	
5	Material Sent For Hardening By (Name)		Lark Porroce	
6	Material Sent For Hardening On Date		27 9 25	
Inspected By (Sign) & Date			Raj! 24/25	

Reviewed by (Engineer-CNC)

Manager-QA