

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.		14590	28/30/105
2	Machined By		V. T. L. H/c Shop	38/46/105
3	Pallet Die No.		14755 (6.0) H/c	1190
4	Die Category	Drg. No.	S. Jumbo	Rev. 00
5	Out Side Diameter	Drg. No.	1059.7 H/c Step 00. 1076.9 H/c	Tapper 8°
6	Inside Diameter	Drg. No.	846.12 H/c (848.12 (R. 850 Step length 48 H/c	
7	Width of Pellet Die	Drg. No.	266 H/c	Under cut = 3.5 H/c
8	Grooves as per Drawing	Drg. No.	45 x 8 x 10.2 H/c / 45 x 8 x 9.2 H/c (8 x 8) H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Face side Step
10	Drilling Area Surface Smoothness		OK	2 H/c Deep Both Side
11	Tapping Operator		H/c Shop	
12	Tapping PCD		952 H/c	Tapping H/c
13	Tapping Hole Diameter		H20. Check by H20 Bolt	of Holes = 2
14	Tapping On Second Side	Half pitch of 1st side	OK	Both Side
15	Tapping Hole Depth		Drill Depth 42.4 H/c Tapping Depth 40 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Savi Shukla	
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	7.0 H/c / 7.5 H/c	1st Rad 7.8 H/c	2nd Rad 7.8 H/c
3	External Relief Depth	7.0 H/c / 7.5 H/c	1st Rad 2.69 H/c	2nd Rad 2.69 H/c
4	Inspection Done Before Hardening By (Name)		Savi	
5	Material Sent For Hardening By (Name)		Lark Purchase	
6	Material Sent For Hardening On Date		8 / 4 / 25	
Inspected By (Sign) & Date			Savi Shukla	

Reviewed by (Engineer-CNC)

Manager-QA