



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)

10011

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		13406	48/97
2	Machined By		N.T.L. H/C Shop	Dr H. 18.02.2008
3	Pallet Die No.		14228(8.0)	Renew
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1043.6 mm	Step 00, 1072.8 mm Tapper 85
6	Inside Diameter	Drg. No.	848.12 mm (Bore 850.14 mm)	Step length 42 mm
7	Width of Pellet Die	Drg. No.	265.5 mm	41.5 mm
8	Grooves as per Drawing	Drg. No.	45x8x9.6 mm	(8+8)
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		H/C Shop	8 mm Deep Boh
12	Tapping PCD		950 mm	Side
13	Tapping Hole Diameter		H2. Check by H2. Ball	Tapping H2
14	Tapping On Second Side	Half pitch of 1st side	ok	of H2. 2
15	Tapping Hole Depth		Drill Depth 42.3 mm	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth 42 mm
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 26/25	
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		Counter 30
2	External Relief Dia	9.0 mm	All Rows	Row 14
3	External Relief Depth		49 mm	
4	Inspection Done Before Hardening By (Name)		Ravi	
5	Material Sent For Hardening By (Name)		Lark Remace	
6	Material Sent For Hardening On Date		26/25	
Inspected By (Sign) & Date			Ravi 26/25	

Reviewed by (Engineer-CNC)

Manager-QA