



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.		13406	48/97
2	Machined By		V. T. L. H/C Shop	Qty H. 1.2.0.12.8
3	Pallet Die No.		14227 (2.0) H	Rev. 00
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1043.6 H	Step 00, 1076.8 H
6	Inside Diameter	Drg. No.	848.14 H	Step length 40 H
7	Width of Pellet Die	Drg. No.	266 H	Under cut 11.5 H
8	Grooves as per Drawing	Drg. No.	45x8x9.6 H / 45x8x9.6 H	(8x8) H
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/C Shop	
12	Tapping PCD		950 H	
13	Tapping Hole Diameter		H20, Check by H20 B.12	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 42.3 H	Tapping Depth 40 H
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	
Inspected By (Sign) & Date			Sasi 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 23
2	External Relief Dia	9.0 H	All Rows	Rev. 14
3	External Relief Depth		49 H	
4	Inspection Done Before Hardening By (Name)		Sasi	
5	Material Sent For Hardening By (Name)		Lark Furnace	
6	Material Sent For Hardening On Date		2 6 25	
Inspected By (Sign) & Date			Sasi 26/25	

Reviewed by (Engineer-CNC)

Manager-QA