



Lark Engineering Company (India) Pvt. Ltd.

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

10038

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.		15072	66/66
2	Machined By		V.T.L. n/c Shop	Dr. H. L. D. 28
3	Pallet Die No.		15161 (12-0)	Rev. 08
4	Die Category	Drg. No.	M. Jumbo	24x3
5	Out Side Diameter	Drg. No.	680.1 mm	Step 005 693 mm
6	Inside Diameter	Drg. No.	546.1 mm	(Box. 548.2) mm
7	Width of Pellet Die	Drg. No.	195 mm	Step length 31 mm
8	Grooves as per Drawing	Drg. No.	32x7x9.1 mm	Under cut = 2.8 mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	(4x8) mm
10	Drilling Area Surface Smoothness		ok	Face Side Step
11	Tapping Operator		n/c Shop	2 mm Deep
12	Tapping PCD		619 mm	Both Side
13	Tapping Hole Diameter		n/c	Tapping n/c
14	Tapping On Second Side	Half pitch of 1st side	Check by HIG Ball	of Holes 2
15	Tapping Hole Depth		ok	Both Side
16	Perpendicularity of Tapped Hole		Drill Depth 33.4 mm	Tapping Depth 31.0
17	Visual Inspection Before Gun Drilling		yes	
			ok	

Inspected By (Sign) & Date

Rev. HIG 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 60
2	External Relief Dia	—	—	nto	Rating			Rev 2 6
3	External Relief Depth	—	—	—	—			
4	Inspection Done Before Hardening By (Name)							Rev. 1
5	Material Sent For Hardening By (Name)							Lark Portare
6	Material Sent For Hardening On Date			7	6	25		

Inspected By (Sign) & Date

Rev. HIG 25

Reviewed by (Engineer-CNC)

Manager-QA