



Lark Engineering Company (India) Pvt. Ltd.

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

10151

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		15277	35/40/62
3	Pallet Die No.		V.T.L H/C Shop	Dry 21.12.2009
4	Die Category	Drg. No.	15165 (G.O) H/C	Rev. 03
5	Out Side Diameter	Drg. No.	H. Jumbo	over 4+3
6	Inside Diameter	Drg. No.	680.7 H/C Shop	693 H/C Tapping 8"
7	Width of Pellet Die	Drg. No.	546.14 H/C (Box - 548.4 H/C)	Step length 31 H/C
8	Grooves as per Drawing	Drg. No.	195 H/C	Under 2.5 H/C
9	Fitting Sizes on CNC Plate	Drg. No.	32.7 x 9.2 H/C / 32.7 x 9.2 H/C (4+2) H/C	
10	Drilling Area Surface Smoothness		OK	Face Side Step
11	Tapping Operator		H/C Shop	2 H/C Deck
12	Tapping PCD		619 H/C	Back Side
13	Tapping Hole Diameter		H162 Check by H16 B/L	Tapping H/C
14	Tapping On Second Side	Half pitch of 1st side	OK	of holes 2
15	Tapping Hole Depth		Drill Depth 33.4 H/C	Back Side
16	Perpendicularity of Tapped Hole		Yes	Tapping Depth 31.2
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Sasi 24/6/13

1	As per programme no.		
2	Gun Drilling Work Completed On		
3	Hole Finish In Gun Drilling	Marked	OK
4	Defective Holes (If Any)		Nil

Note : Mark the defective holes/Missed holes with the help of Permanent Marker

Counter = 35
Row = 12

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	6.5 H/C / 7.0 H/C	6.5 H/C	All Rows 23 H/C			
3	External Relief Depth		7.0 H/C	All Rows 26 2 H/C			
4	Inspection Done Before Hardening By (Name)		Sasi				
5	Material Sent For Hardening By (Name)		Lark Forance				
6	Material Sent For Hardening On Date		24	6	25		

Inspected By (Sign) & Date

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Reviewed by (Engineer-CNC)

Manager-QA