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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.		15202	30/45
2	Machined By		N.T.L. M/C Shop	Drg No. 18.0.483
3	Pallet Die No.		15747 (5.0)	Rev. 04
4	Die Category	Drg. No.	Junior	
5	Out Side Diameter	Drg. No.	400 mm	Step 00 = 389 mm Step length 10.5
6	Inside Diameter	Drg. No.	310.12 mm	
7	Width of Pellet Die	Drg. No.	134 mm	
8	Grooves as per Drawing	Drg. No.	8 x 7 x 3 mm / 8 x 7 x 3 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		M/C Shop	
12	Tapping PCD		350 mm	
13	Tapping Hole Diameter		1/2" = Crack by 1/2" Tap	Tapping of 1/2" = 8 Both Side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 16.6 mm	Tapping Depth 14.5
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Rev. 21/6/15

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 63
2	External Relief Dia	5.5 mm	Outside (2-2)			Inner				60.15
3	External Relief Depth		20 mm			15 mm				
4	Inspection Done Before Hardening By (Name)					Ravi				
5	Material Sent For Hardening By (Name)					Lark Furnace				
6	Material Sent For Hardening On Date			21	6	25				

Inspected By (Sign) & Date

Ravi 21/6/15

Reviewed by (Engineer-CNC)

Manager-QA