



Lark Engineering Company (India) Pvt. Ltd.

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

10352

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.		15464	58/66
2	Machined By		V. T. L. H/C Shop	Dry H. 18.2.320
3	Pallet Die No.		15550(9.0) H/C	Rev. 08
4	Die Category	Drg. No.	M. Tomba	
5	Out Side Diameter	Drg. No.	680.1 H/C	Step 0.1 692.9 H/C
6	Inside Diameter	Drg. No.	546.14 H/C (Bor. 548.2)	Step length 2.1 H/C
7	Width of Pellet Die	Drg. No.	195 H/C	Under cut 2.8 H/C
8	Grooves as per Drawing	Drg. No.	32.7 x 9.1 H/C / 32.7 x 9.1 H/C (4x8) H/C	
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	[Race Side Step]
11	Tapping Operator		H/C Shop	2 H/C Deep
12	Tapping PCD		619 H/C	Both Side
13	Tapping Hole Diameter		H/C, Check by H/C Bolt	[Tapping Holes]
14	Tapping On Second Side	Half pitch of 1st side	ok	of Holes, 2
15	Tapping Hole Depth		Drill Depth. 33.6 H/C	Both Side
16	Perpendicularity of Tapped Hole		yes	Tapping Depth. 31.6 H/C
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

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

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

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	10.0 H/C		All Rows					
3	External Relief Depth			8 H/C					
4	Inspection Done Before Hardening By (Name)			Ravi					
5	Material Sent For Hardening By (Name)			Lark Porrace					
6	Material Sent For Hardening On Date		24	7	25				
Inspected By (Sign) & Date									

Satish 24/7/13

Ravi 24/7/13

Reviewed by (Engineer-CNC)

Manager-QA