



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.		15457	62/105
2	Machined By		V.T.L. n/c Shop	Dy. 12.0.1190
3	Pallet Die No.		15462 (8.0) n/c	Rev. 100
4	Die Category	Drg. No.	S. Jumbo	
5	Out Side Diameter	Drg. No.	1059.7 n/c Step 00	1077 n/c Tapp. 8
6	Inside Diameter	Drg. No.	848.14 n/c / 847.14 n/c (Bore 85.0)	Step length 4.2
7	Width of Pellet Die	Drg. No.	256 n/c	Order width = 3.5 n/c
8	Grooves as per Drawing	Drg. No.	45 x 8 x 9.2 n/c / 45 x 8 x 9.7 n/c	(8 x 8) n/c
9	Fitting Sizes on CNC Plate	Drg. No.	ok	Face Side 9.2
10	Drilling Area Surface Smoothness		ok	2 n/c Rec. 12.12.13
11	Tapping Operator		n/c Shop	Tapping 10
12	Tapping PCD		952 n/c	of 1.1222
13	Tapping Hole Diameter		M20 Check by M20 Bolt	Both Side
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 48.3 n/c	Tapping Depth 39.3
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Rev. 19/12/15

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

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1	Counter Sinking Depth & Finish	ok							Rev. 14
2	External Relief Dia	9.0 n/c	All Rows						
3	External Relief Depth		45 n/c						
4	Inspection Done Before Hardening By (Name)		Ravi						
5	Material Sent For Hardening By (Name)		Lark Furnace						
6	Material Sent For Hardening On Date		19	7	25				

Inspected By (Sign) & Date

Rev. 19/12/15

Satya
19/7/15
Reviewed by (Engineer-CNC)

Manager-QA