



Lark Engineering Company (India) Pvt. Ltd.

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

10822

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.		16198	36/64/78
2	Machined By		UTL m/c Shop	Qty No 1325 (Rev)
3	Pallet Die No.		16830 (6.5) mm	
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	636 mm	Step on 630.5/343 mm
6	Inside Diameter	Drg. No.	425 mm	Step Length 26/16.5
7	Width of Pellet Die	Drg. No.	182 mm	and Step length 23
8	Grooves as per Drawing	Drg. No.	27x12x8x9.5/37x12x8x9.5	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		m/c Shop	Tapping No of
12	Tapping PCD		540 mm	Hole in
13	Tapping Hole Diameter		7/6 Check by m/c Salf	Both side
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 28.5 mm	Tapping Depth 26.5 mm
16	Perpendicularity of Tapped Hole		X18	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahesh 8/10/13

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

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

1	Counter Sinking Depth & Finish	OK					Counter 30°
2	External Relief Dia	outer 7 mm		inner 7.5 mm			Rev - 9
3	External Relief Depth	45.5 mm		14.8 mm			
4	Inspection Done Before Hardening By (Name)			Mahesh			
5	Material Sent For Hardening By (Name)			Hard Turnover			
6	Material Sent For Hardening On Date			8	10	SS	

Inspected By (Sign) & Date

Mahesh

Reviewed by (Engineer-CNC)

Manager-QA