

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.		16182	28/66 & 28/66
2	Machined By		VTL - M/C Shop	Drg No 220 R8
3	Pallet Die No.		16455 7.0 mm	
4	Die Category	Drg. No.	M-Jumbo	
5	Out Side Diameter	Drg. No.	680.1 mm	Step OD 693.1 mm
6	Inside Diameter	Drg. No.	546.12 mm	Step length 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	
8	Grooves as per Drawing	Drg. No.	82X7X4X9.1 mm	
9	Fitting Sizes on CNC Plate	Drg. No.	012	Tapping No of
10	Drilling Area Surface Smoothness		OK	Hole 2
11	Tapping Operator		M/C Shop	Both Side
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		M 16 Check By M 16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill depth 33.5 Tapping Depth 32.5	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Mahesh / Sanjeev

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	8 mm	2st. Pad	2nd Pad	3rd Pad			Row - 4 - 4
3	External Relief Depth		40 mm	38 mm				
4	Inspection Done Before Hardening By (Name)							Mahesh / Sanjeev
5	Material Sent For Hardening By (Name)							Lark furnace
6	Material Sent For Hardening On Date		6	10	28			
Inspected By (Sign) & Date		Mahesh 6/10/28						

Reviewed by (Engineer-CNC)

Manager-QA