



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.		15701	6/66
2	Machined By		UTL m/c shop	Drg No 9136 (Pof)
3	Pallet Die No.		16443	
4	Die Category	Drg. No.	S. Jumbo (3.5) mm	
5	Out Side Diameter	Drg. No.	1032 mm - 8 step op 1033 mm	
6	Inside Diameter	Drg. No.	900 mm	Step length 37 mm
7	Width of Pellet Die	Drg. No.	375 mm	
8	Grooves as per Drawing	Drg. No.	29.5 x 8 x 13	Tapping No of
9	Fitting Sizes on CNC Plate	Drg. No.	OK	Hole 15
10	Drilling Area Surface Smoothness		OK	Both side
11	Tapping Operator		M/c shop	
12	Tapping PCD		970 mm	
13	Tapping Hole Diameter		m24 Check by m24 Ball	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth 38.5 mm Tapping Depth 36.5	
16	Perpendicularity of Tapped Hole		X20	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Makeh

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					Center 60°
2	External Relief Dia	3.5 mm	60x22 (4-4)		inner 8		
3	External Relief Depth		12.6		64mm		
4	Inspection Done Before Hardening By (Name)		Makeh				
5	Material Sent For Hardening By (Name)		Lark Furnace				
6	Material Sent For Hardening On Date		8	10	95		

Inspected By (Sign) & Date

Makeh 8/10/98

Reviewed by (Engineer-CNC)

Manager-QA