



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)

10881

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		16241	17166
2	Machined By		V. T. L. n/c Shop	Dr. H. 12.0.2009
3	Pallet Die No.		16464 (6.0) mm	Rev. 03
4	Die Category	Drg. No.	M. Jumbo	
5	Out Side Diameter	Drg. No.	680.7 mm	Step 00. 682.9 mm
6	Inside Diameter	Drg. No.	546.14 mm	(Bar. 548.4) Step length. 31 mm
7	Width of Pellet Die	Drg. No.	195 mm	Under cut. 2.5 mm
8	Grooves as per Drawing	Drg. No.	32.7 x 9.2 mm	32.7 x 9.2 mm (4 x 8) mm
9	Fitting Sizes on CNC Plate	Drg. No.	ok	
10	Drilling Area Surface Smoothness		ok	
11	Tapping Operator		n/c Shop	
12	Tapping PCD		619 mm	
13	Tapping Hole Diameter		H16. Check by H16 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth. 33.4 mm	Tapping Depth. 31.4 mm
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 14/10/15

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

Counter. 30

1	Counter Sinking Depth & Finish	ok							
2	External Relief Dia	7.5 mm			All Rows				
3	External Relief Depth				49 mm				
4	Inspection Done Before Hardening By (Name)				Ravi				
5	Material Sent For Hardening By (Name)				Lark Furnace				
6	Material Sent For Hardening On Date		14	10	25				

Inspected By (Sign) & Date

Ravi 14/10/15

Satya 14/10/15

Reviewed by (Engineer-CNC)

Manager-QA