



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)

6713

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10936	45/60
2	Machined By		V.T.L. H/c Shop	Drg. No. 1 & 02
3	Pallet Die No.		10768 (4.0) H/c	Rev. 2.00
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	780 H/c, Step OD = 792 H/c	Step length = 0.65
6	Inside Diameter	Drg. No.	660.12 H/c	Under cut = 6 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	21.5 x 8 x 8 H/c / 21.5 x 8 x 8 H/c	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		H/c Shop	Tapping No. of Holes = 12 Both Side
12	Tapping PCD		785 H/c	
13	Tapping Hole Diameter		M20 - Check by M20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	OK	
15	Tapping Hole Depth		Drill Depth = 32 H/c Tapping Depth = 29.7 H/c	
16	Perpendicularity of Tapped Hole		Yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 31/124

1	As per programme no.			2 slot 32 H/c width 8 H/c Depth Both side
2	Gun Drilling Work Completed On			
3	Hole Finish In Gun Drilling	Marked	OK	
4	Defective Holes (If Any)		No - 7 Hole Colused (A)	

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

Counter = 60°

1	Counter Sinking Depth & Finish	OK					
2	External Relief Dia	4.5 H/c	outside (3-3)	Inner			
3	External Relief Depth		23 H/c	15 H/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		3	1	24		

Inspected By (Sign) & Date

Ravi 31/124

Signature
31/124

Reviewed by (Engineer-CNC)

Manager-QA