



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

Inprocess Inspection (Pellet Dies)

Rev. Date

31-07-2013

6686

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10849	05/03/13
2	Machined By		V.T.L. w/c Shop	Drg. No. L.S.O. 396
3	Pallet Die No.		10899 (6.0) H4	Rec. 02
4	Die Category	Drg. No.	N. Jumbo	
5	Out Side Diameter	Drg. No.	636 H4 / 632 H4 Step 002	630.5 H4 / 543 H4
6	Inside Diameter	Drg. No.	480.1 H4 / 489.1 H4 / 500.1 H4	Step lengths 26 H4
7	Width of Pellet Die	Drg. No.	182 H4	16.5 H4
8	Grooves as per Drawing	Drg. No.	27x12x7.8x9.5 H4 / 37x12x7.8x9.5 H4	
9	Fitting Sizes on CNC Plate	Drg. No.	OK	
10	Drilling Area Surface Smoothness		OK	
11	Tapping Operator		w/c Shop	Tapping No. Holes = 4
12	Tapping PCD		540 H4	
13	Tapping Hole Diameter		H16 = Check by H16 Ball	
14	Tapping On Second Side	Half pitch of 1st side	One Side Tapping and 1st Side One Slot	
15	Tapping Hole Depth		Drill Depth 29 H4 Tapping Depth = 27 H4	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		OK	

Inspected By (Sign) & Date

Ravi 23/12/13

1	As per programme no.			1 Slot 28.1 H4 Width 17 H4 Deep
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 = 60°

1	Counter Sinking Depth & Finish	OK								
2	External Relief Dia	7.0 H4 / 7.5 H4	7.0 H4 All Lines	7.5 H4 All Lines						
3	External Relief Depth		43 H4	15 H4						
4	Inspection Done Before Hardening By (Name)		Ravi							
5	Material Sent For Hardening By (Name)		Lark Furnace							
6	Material Sent For Hardening On Date		23	12	23					

Inspected By (Sign) & Date

Ravi 23/12/13

Reviewed by (Engineer-CNC)

Manager-QA