



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.		10394	33/5/13
2	Machined By		V.T.L. H/c Shop	Dy. Insp. L.S.D. 393
3	Pallet Die No.		11518 (3.8) H/c	Revised
4	Die Category	Drg. No.	Jumbo	
5	Out Side Diameter	Drg. No.	830 H/c, Step 00, 822 H/c	Tapping 4"
6	Inside Diameter	Drg. No.	700.12 H/c	Step length 33 H/c
7	Width of Pellet Die	Drg. No.	324 H/c	
8	Grooves as per Drawing	Drg. No.	30x8x8.5 H/c 30x8x8.5 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		760 H/c	
13	Tapping Hole Diameter		M 22 = Check by M 22 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth 37.4 H/c	Tapping Depth 34.7
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	
Inspected By (Sign) & Date			Ravi 26/7/13	
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 = 60° Low = 46
2	External Relief Dia	4.3 H/c 4.8 H/c	4.3 H/c All Lines 4.8 H/c All Lines	
3	External Relief Depth		32 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		26 12 23	
Inspected By (Sign) & Date			Ravi 26/7/13	

Reviewed by (Engineer-CNC)

Manager-QA