



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

S.No.	Check Parameter	Specification	Observations	Remarks
1	Work Order No.		10935	37/43
2	Machined By		V.T.L. H/c Shop	Drg No. 1.5.0. 940
3	Pallet Die No.		11260 (3.5) H/c	Rev. No.
4	Die Category	Drg. No.	Extra wide	
5	Out Side Diameter	Drg. No.	606 H/c / Step 00 = 612 H/c	Step length = 2 H/c
6	Inside Diameter	Drg. No.	52.12 H/c	Under cut = 3 H/c
7	Width of Pellet Die	Drg. No.	222 H/c	
8	Grooves as per Drawing	Drg. No.	13x8x5 H/c / 13x8x5 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		565 H/c	
13	Tapping Hole Diameter		H2 = Check by H20 Bolt	
14	Tapping On Second Side	Half pitch of 1st side	ok	
15	Tapping Hole Depth		Drill Depth = 21.2 H/c Tapping Depth = 19 H/c	
16	Perpendicularity of Tapped Hole		yes	
17	Visual Inspection Before Gun Drilling		ok	

Inspected By (Sign) & Date

Ravi 27/7/13

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

Counter = 60

1	Counter Sinking Depth & Finish	ok								Rev. No. 34
2	External Relief Dia	4.0 H/c	All Rows							
3	External Relief Depth		6 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		27	12	23					

Inspected By (Sign) & Date

Ravi 27/7/13

Reviewed by (Engineer-CNC)

Manager-QA