

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.			
2	Machined By		11112	28/48/66
3	Pallet Die No.		N.T.L. n/c Shop	Dy No. 1.8.0 = 609
4	Die Category	Drg. No.	11485 (6-0) n/c	Rev = 01
5	Out Side Diameter	Drg. No.	M-Jumbo	
6	Inside Diameter	Drg. No.	680.69 n/c, Step 0.2, 692.7 n/c Step length 31 n/c	
7	Width of Pellet Die	Drg. No.	548.12 n/c	Tapper = 8°
8	Grooves as per Drawing	Drg. No.	195 n/c	Under cut = 2.4 n/c
9	Fitting Sizes on CNC Plate	Drg. No.	32x7x8 n/c 32x7x8 n/c (4x8) n/c	
10	Drilling Area Surface Smoothness		ok	Face Side Step 8 n/c Back Side
11	Tapping Operator		ok	
12	Tapping PCD		n/c Shop	Tapping No. of holes = 4
13	Tapping Hole Diameter		619 n/c	Back Side
14	Tapping On Second Side	Half pitch of 1st side	HIG = Check by HIG Bolt	
15	Tapping Hole Depth		ok	
16	Perpendicularity of Tapped Hole		Dull Depth = 33.5 n/c Tapping Depth = 31.2 n/c	
17	Visual Inspection Before Gun Drilling		yes ok	

Inspected By (Sign) & Date

Ravi 28/12/14

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						Counter = 3°
2	External Relief Dia	6.5 n/c 7.0 n/c	6.5 n/c All Rows	7.0 n/c All Rows			Relief = 12
3	External Relief Depth		28 n/c	18 n/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		28	1	24		

Inspected By (Sign) & Date

Ravi 28/12/14

29/1/14

viewed by (Engineer-CNC)

Manager-QA